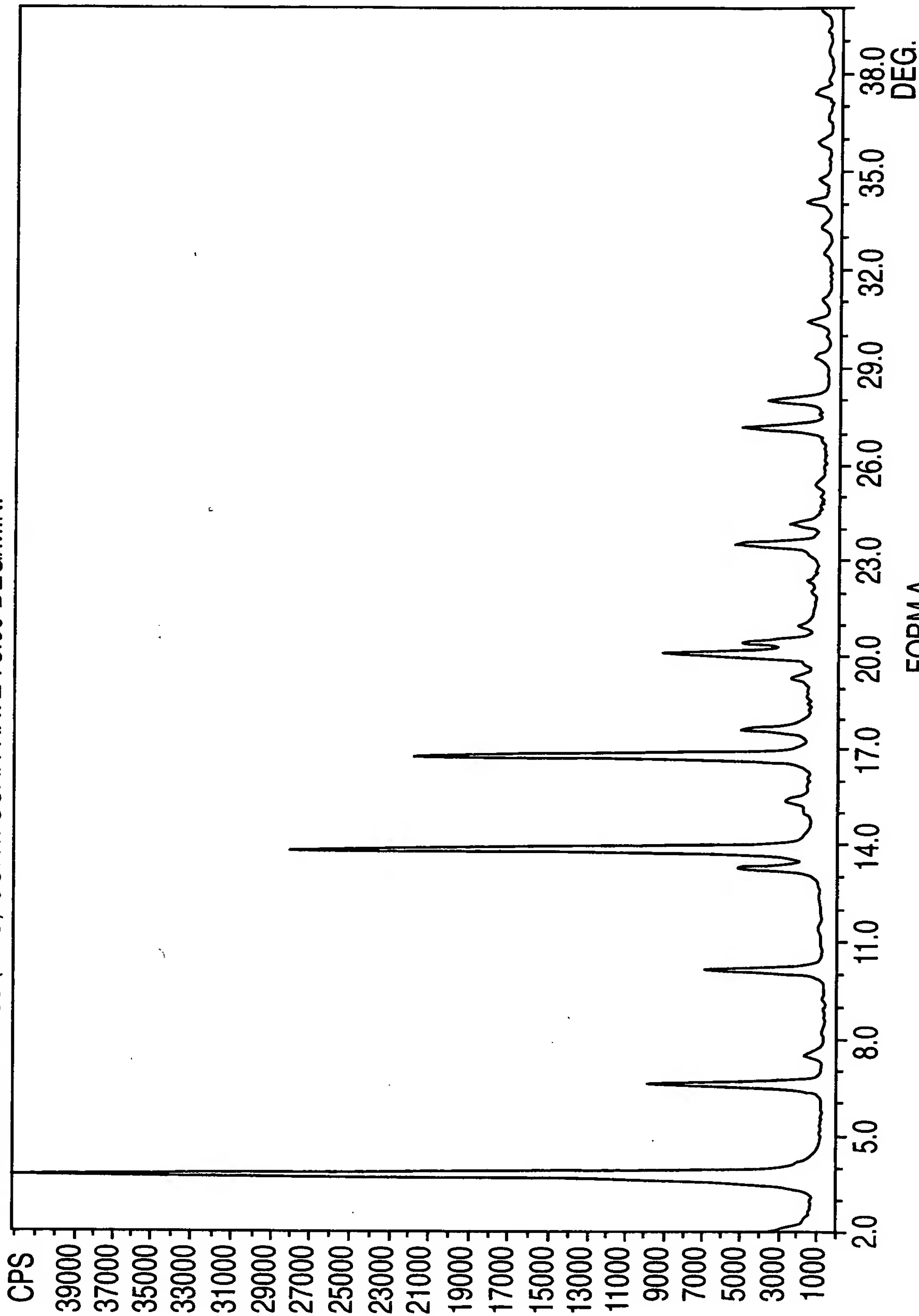




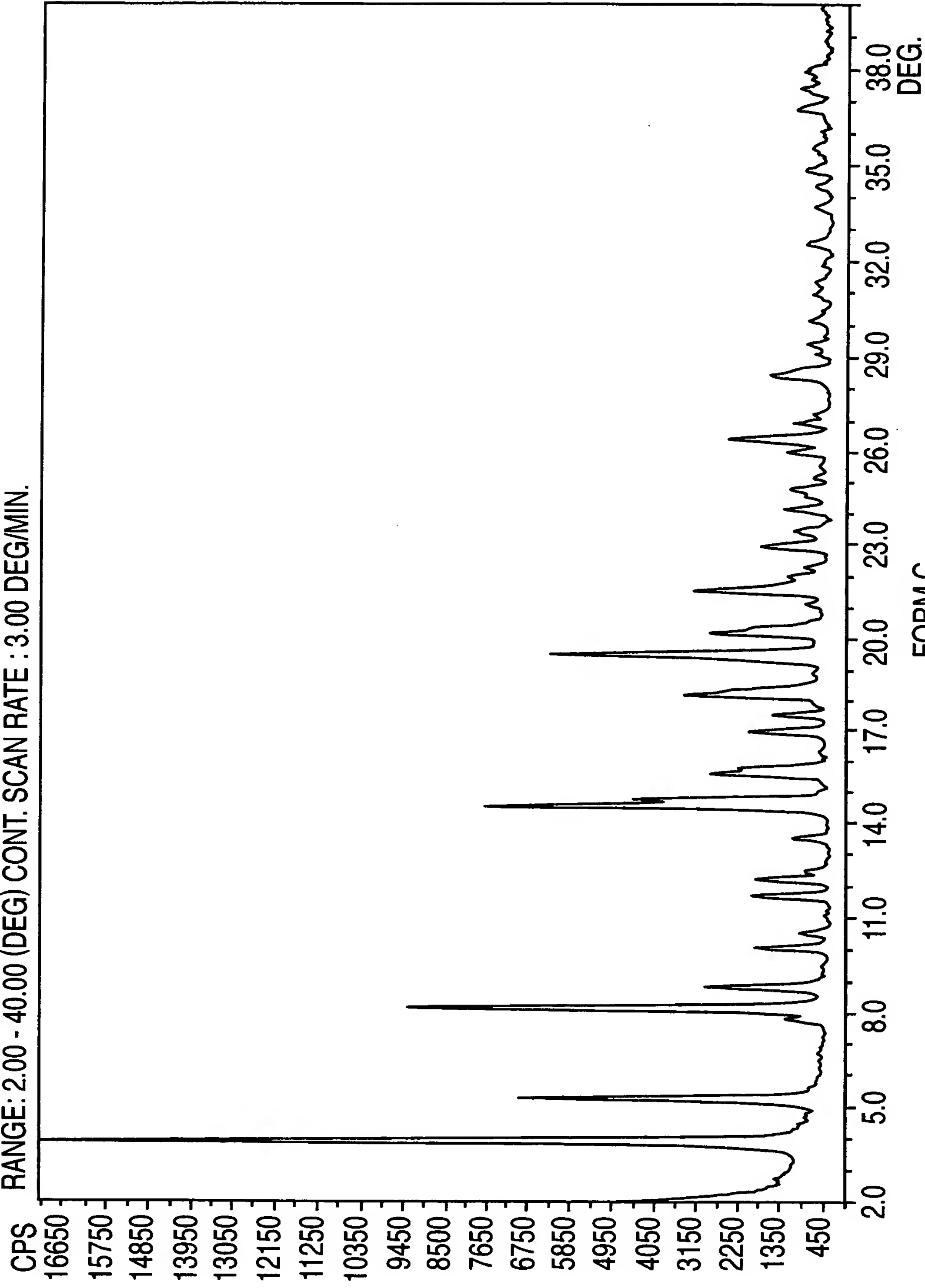
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STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



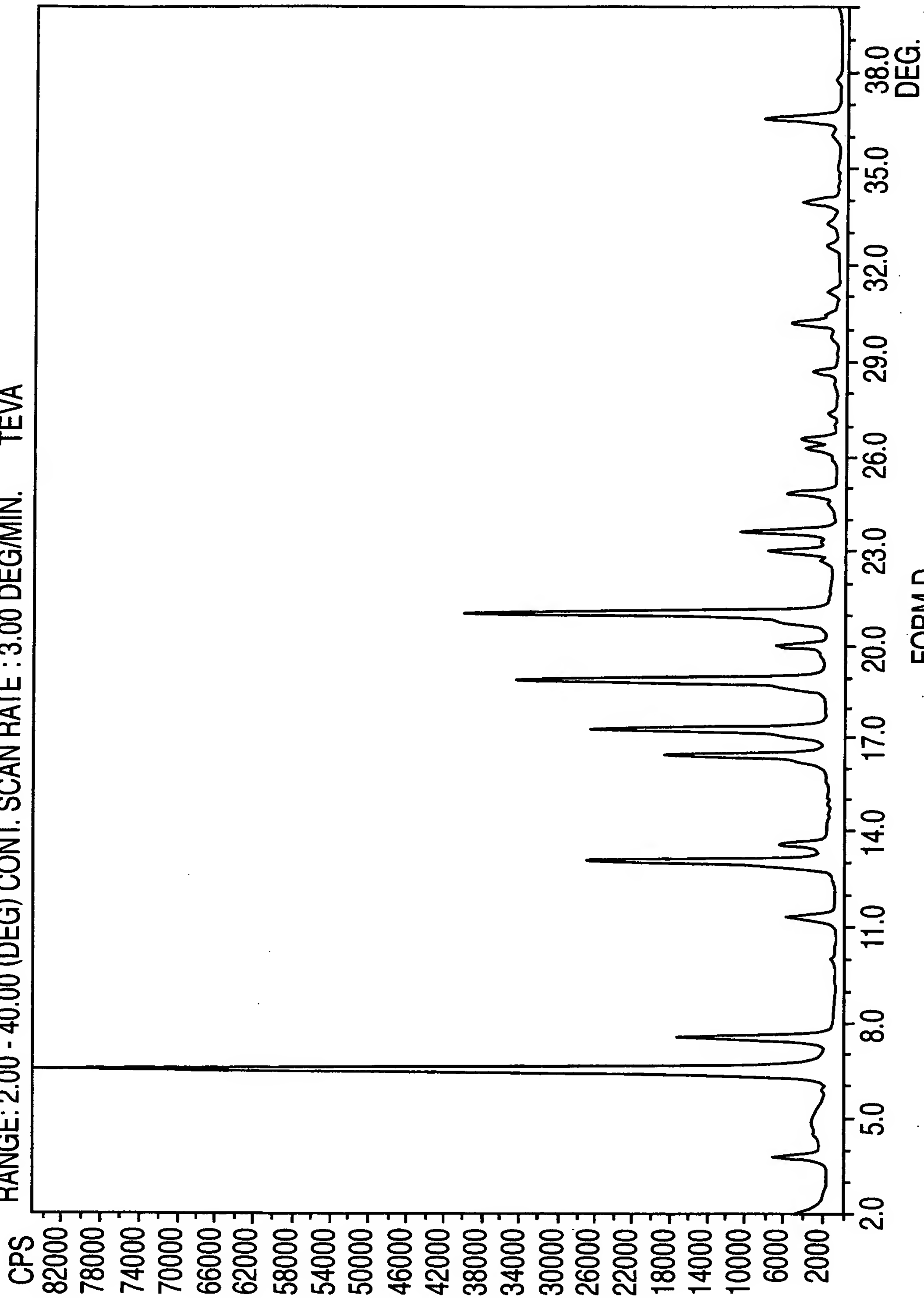
FORM A
FIG. 1

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



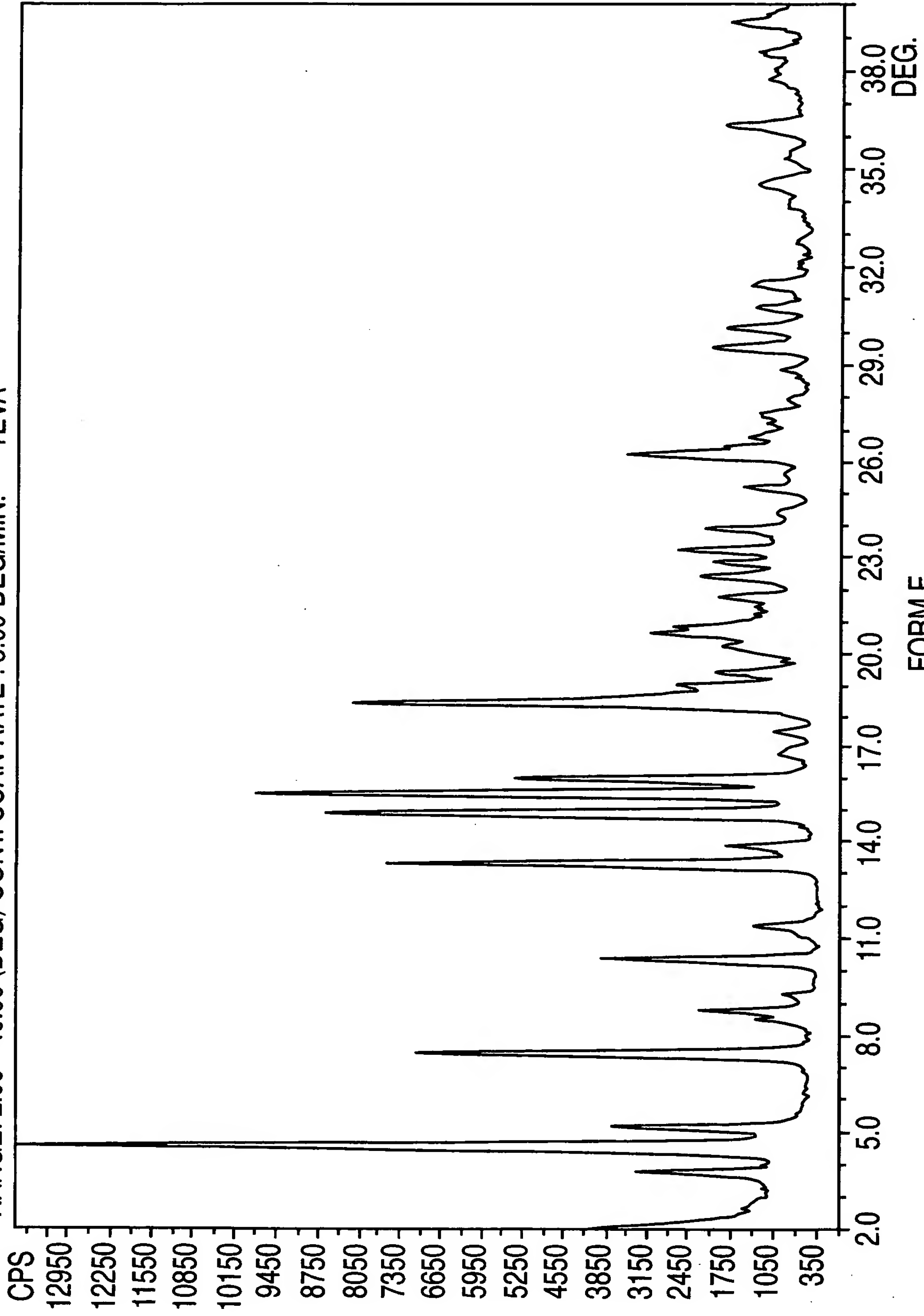
FORM C
FIG. 2

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN. TEVA



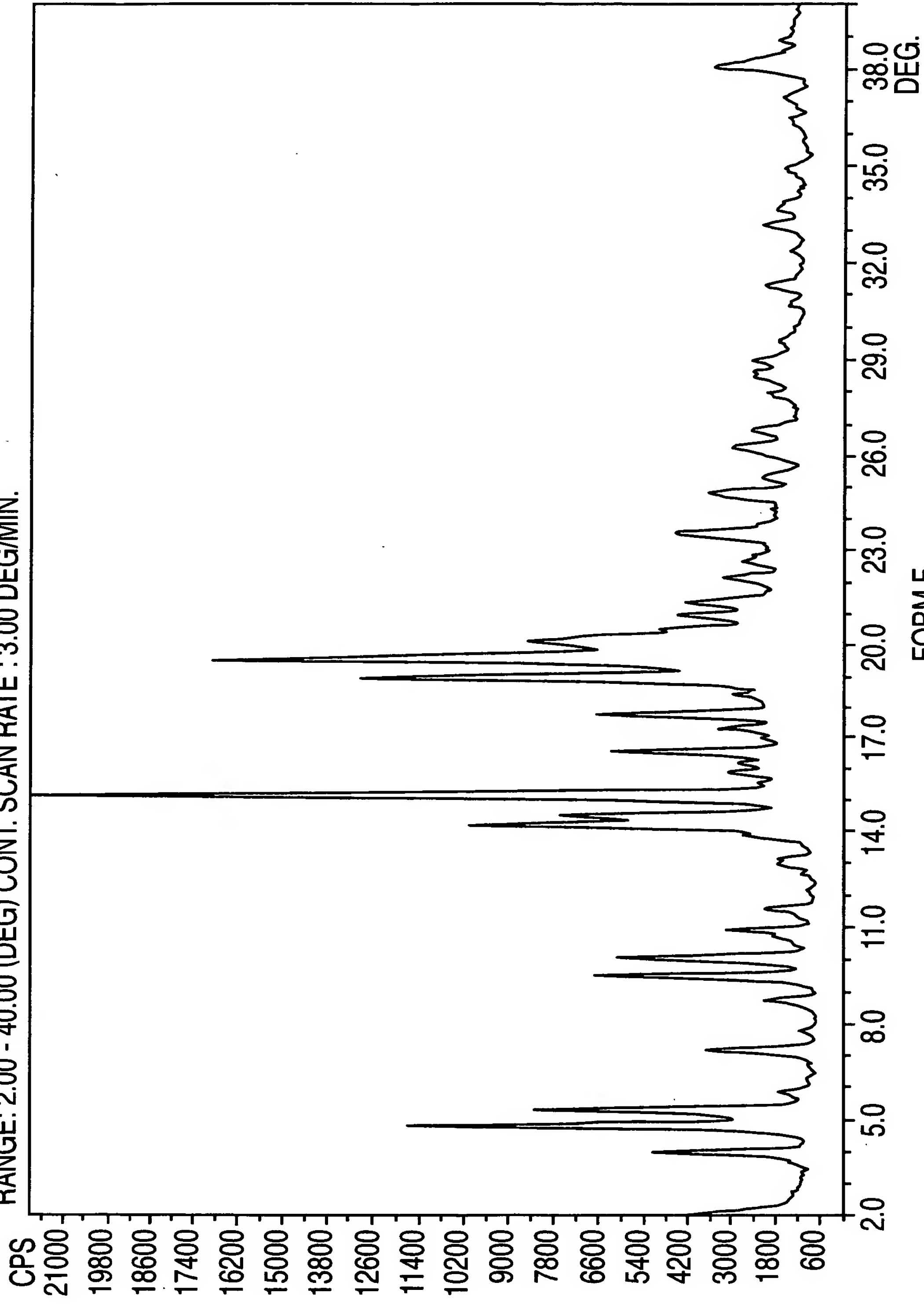
FORM D
FIG. 3

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN. TEVA



FORM E
FIG. 4

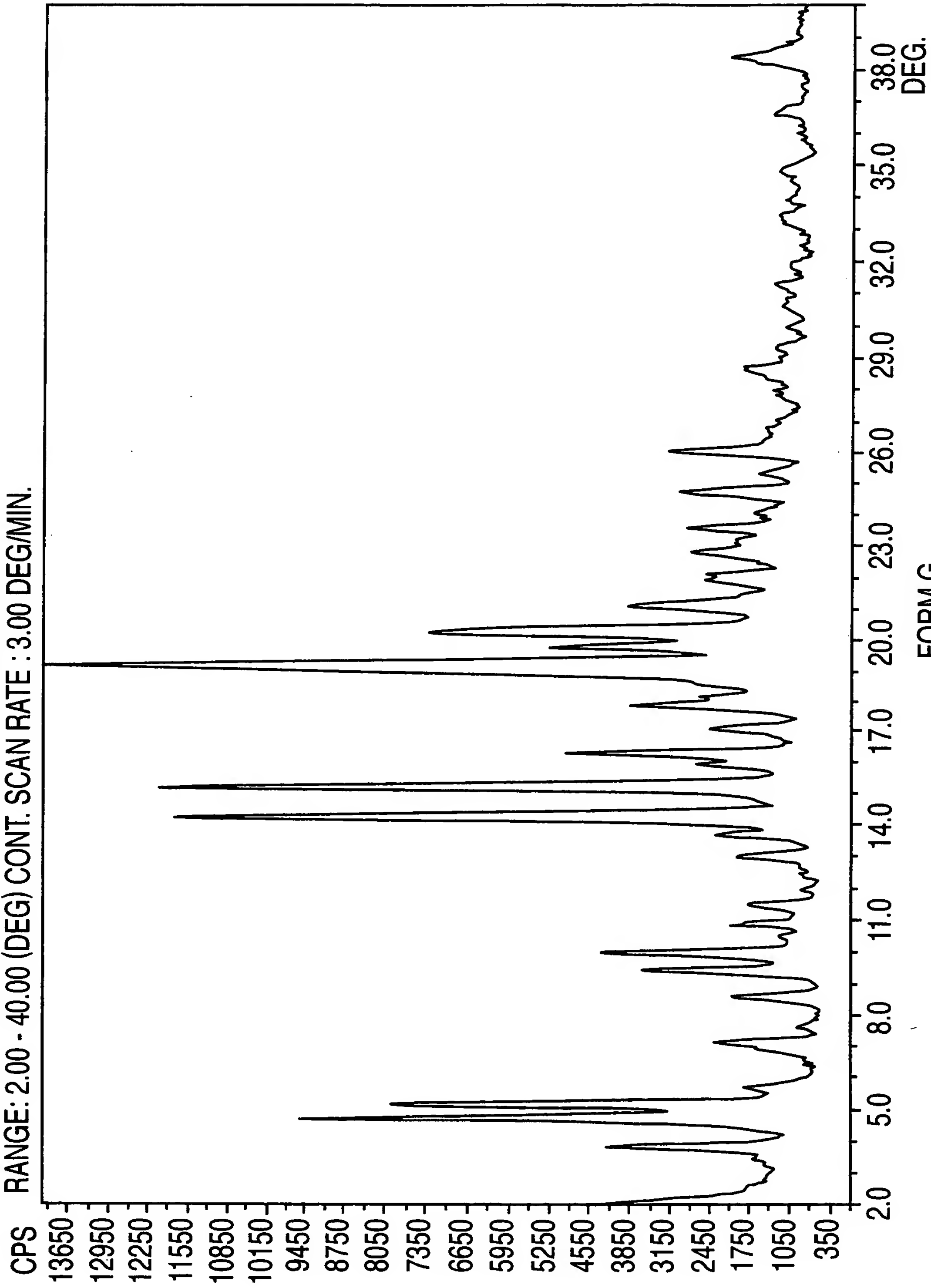
STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM F

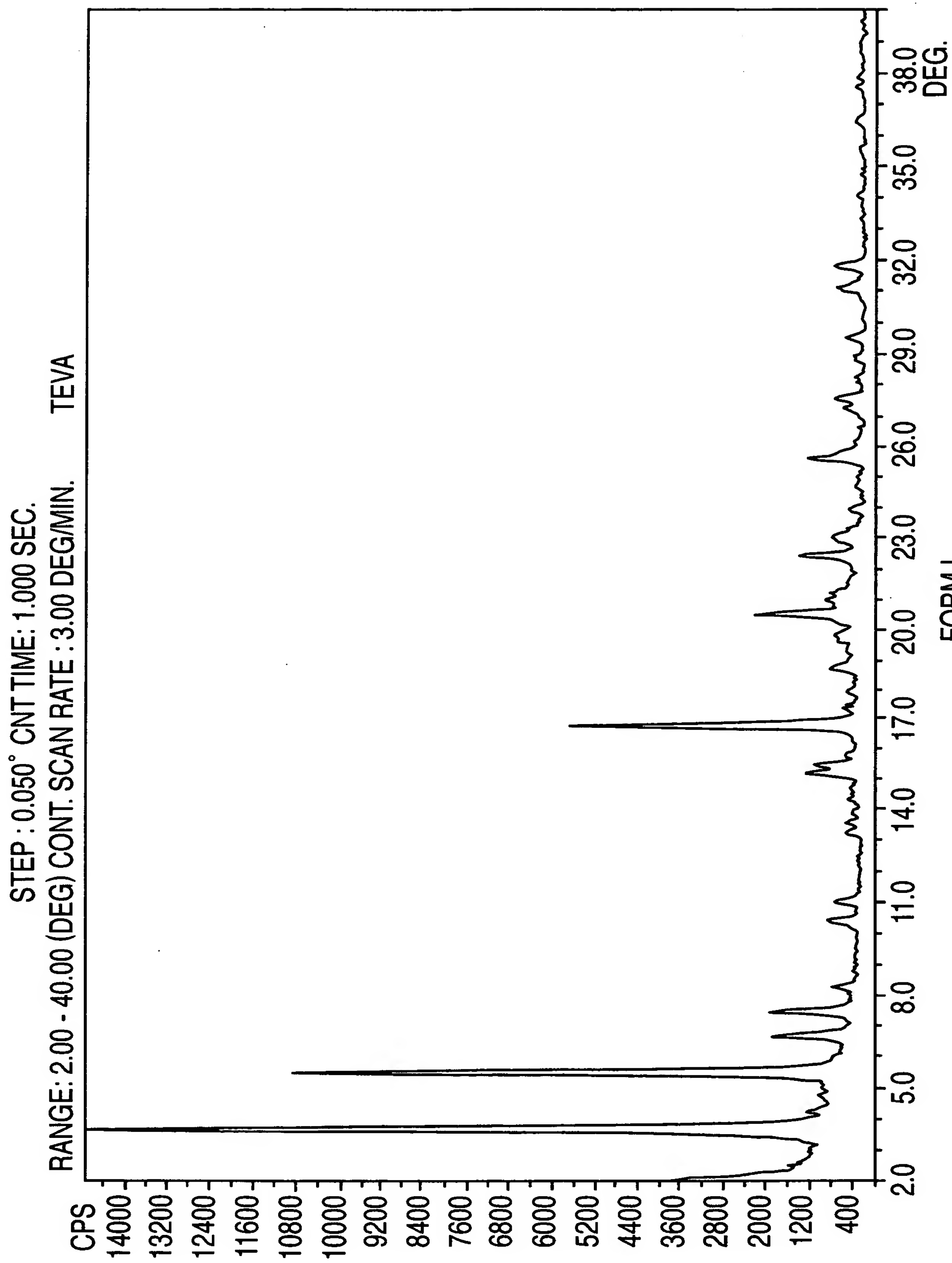
FIG. 5

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM G

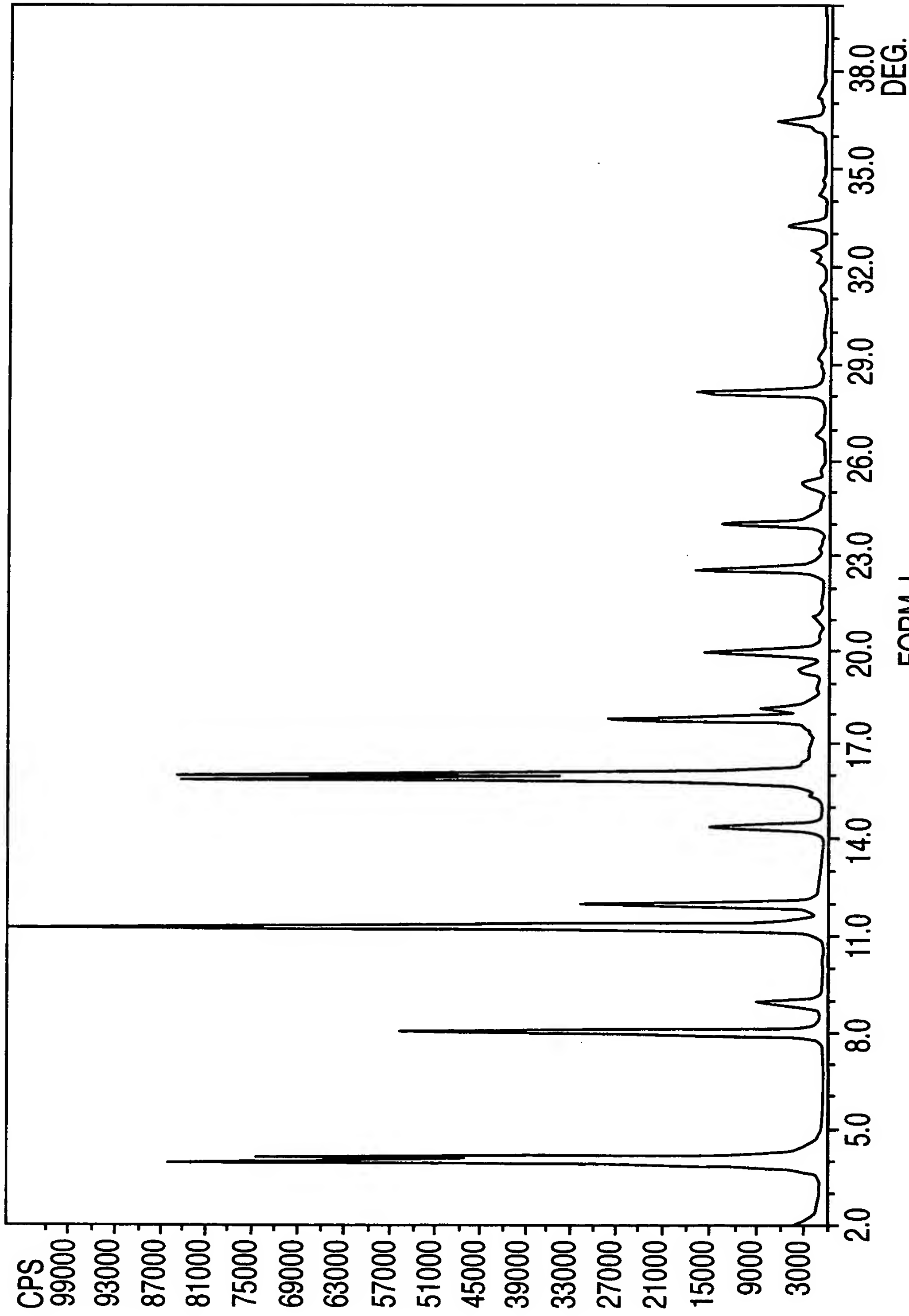
FIG. 6



FORM I

FIG. 7

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM J
FIG. 8

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

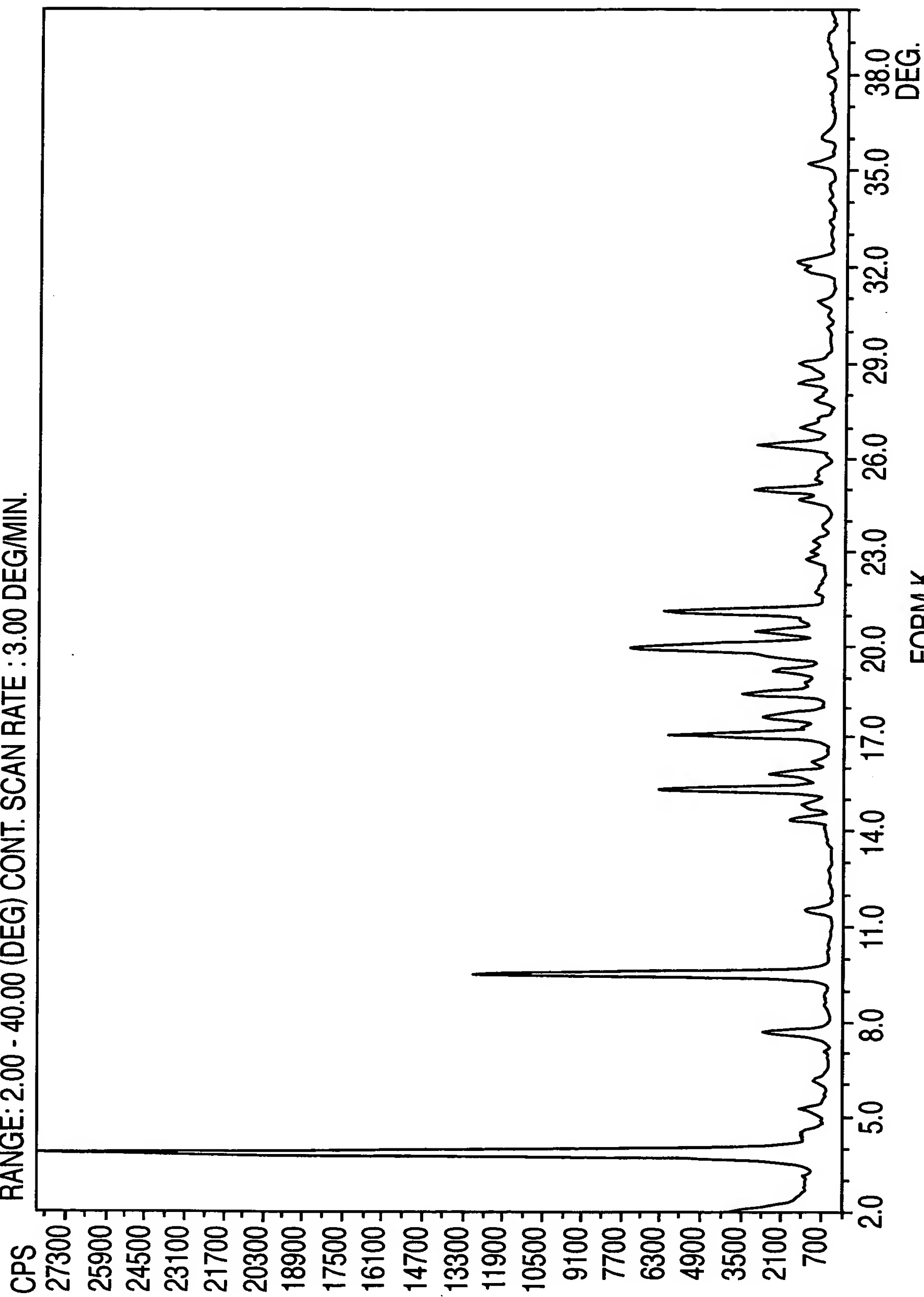
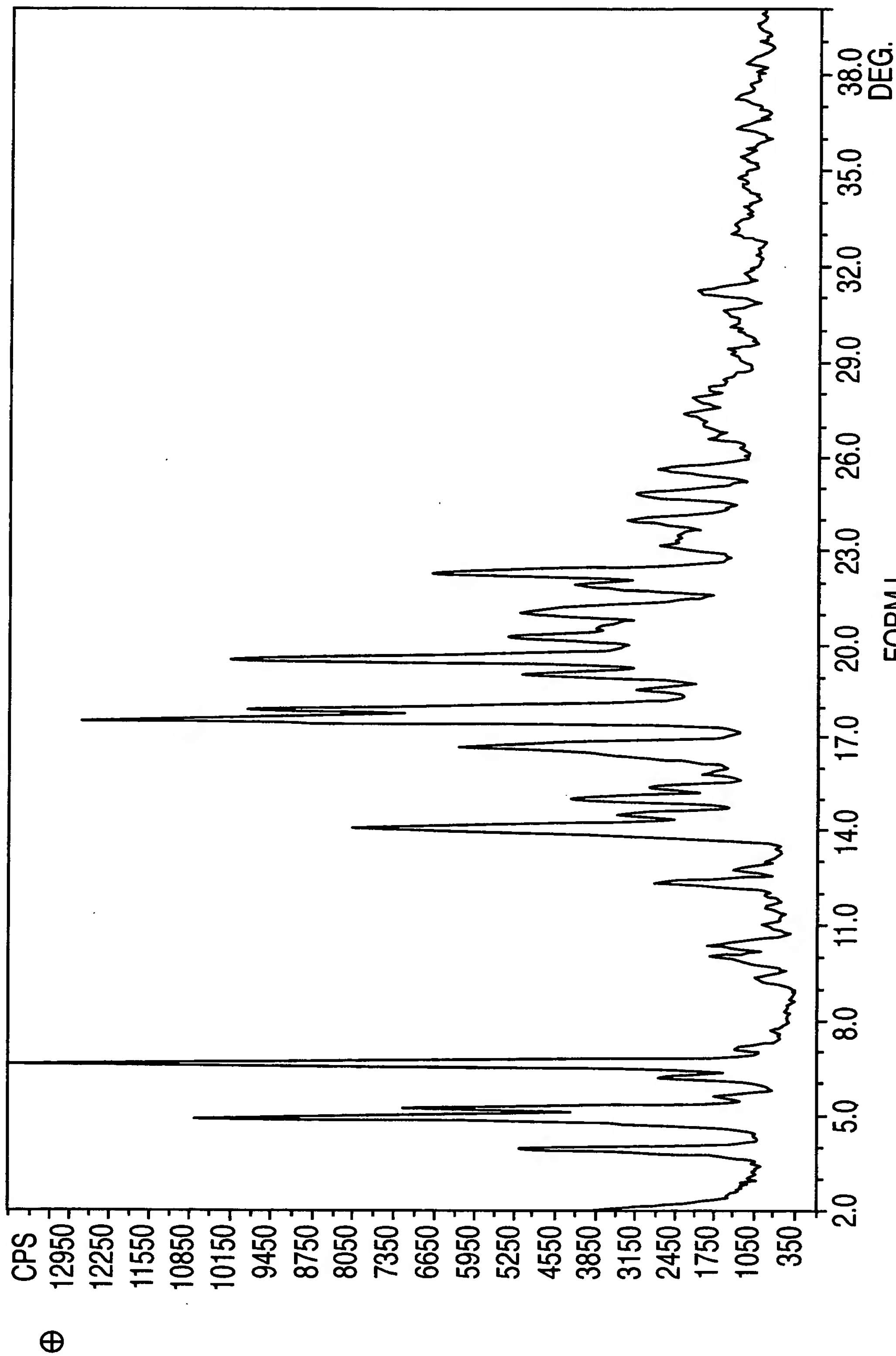


FIG. 9

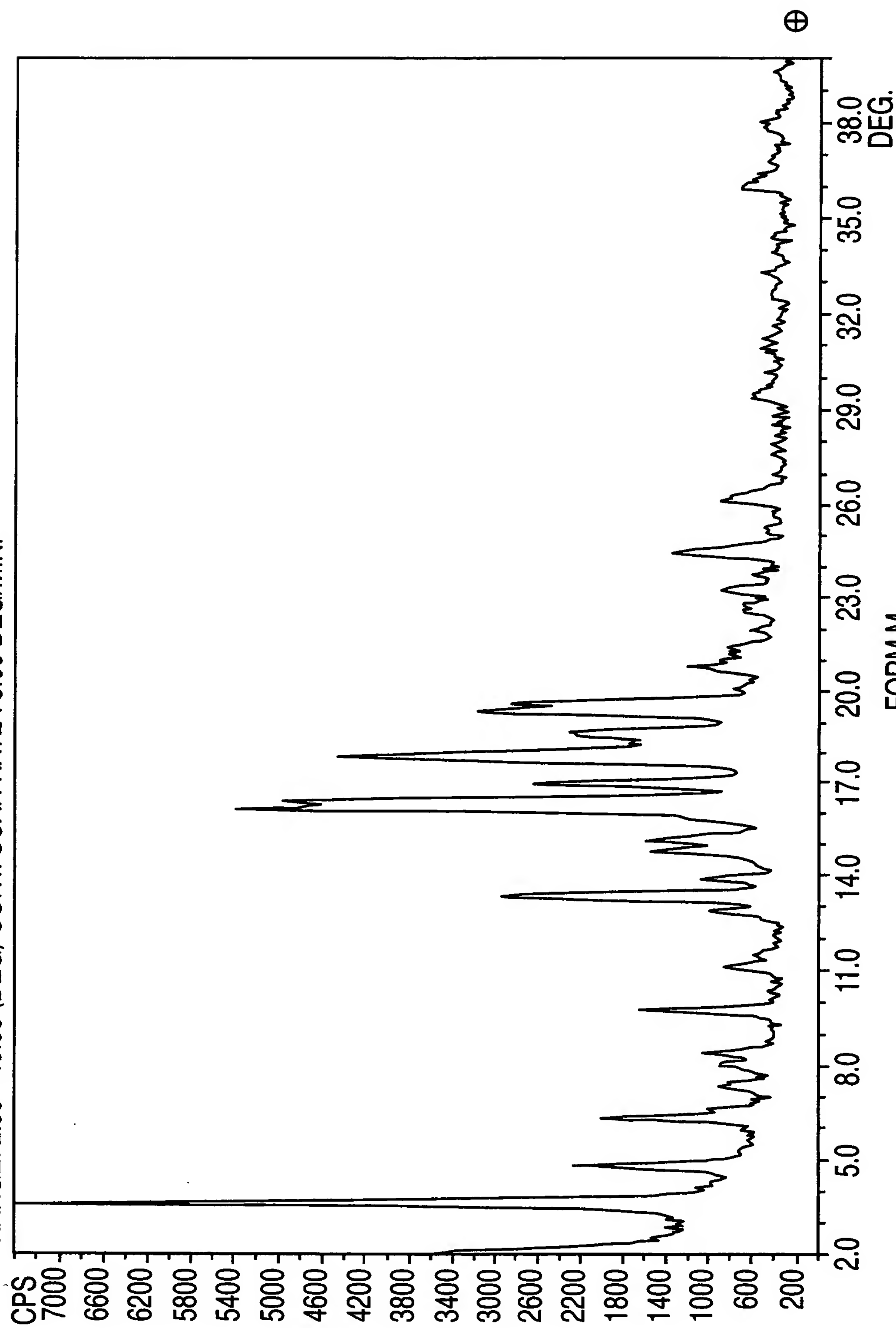
STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM L
FIG. 10

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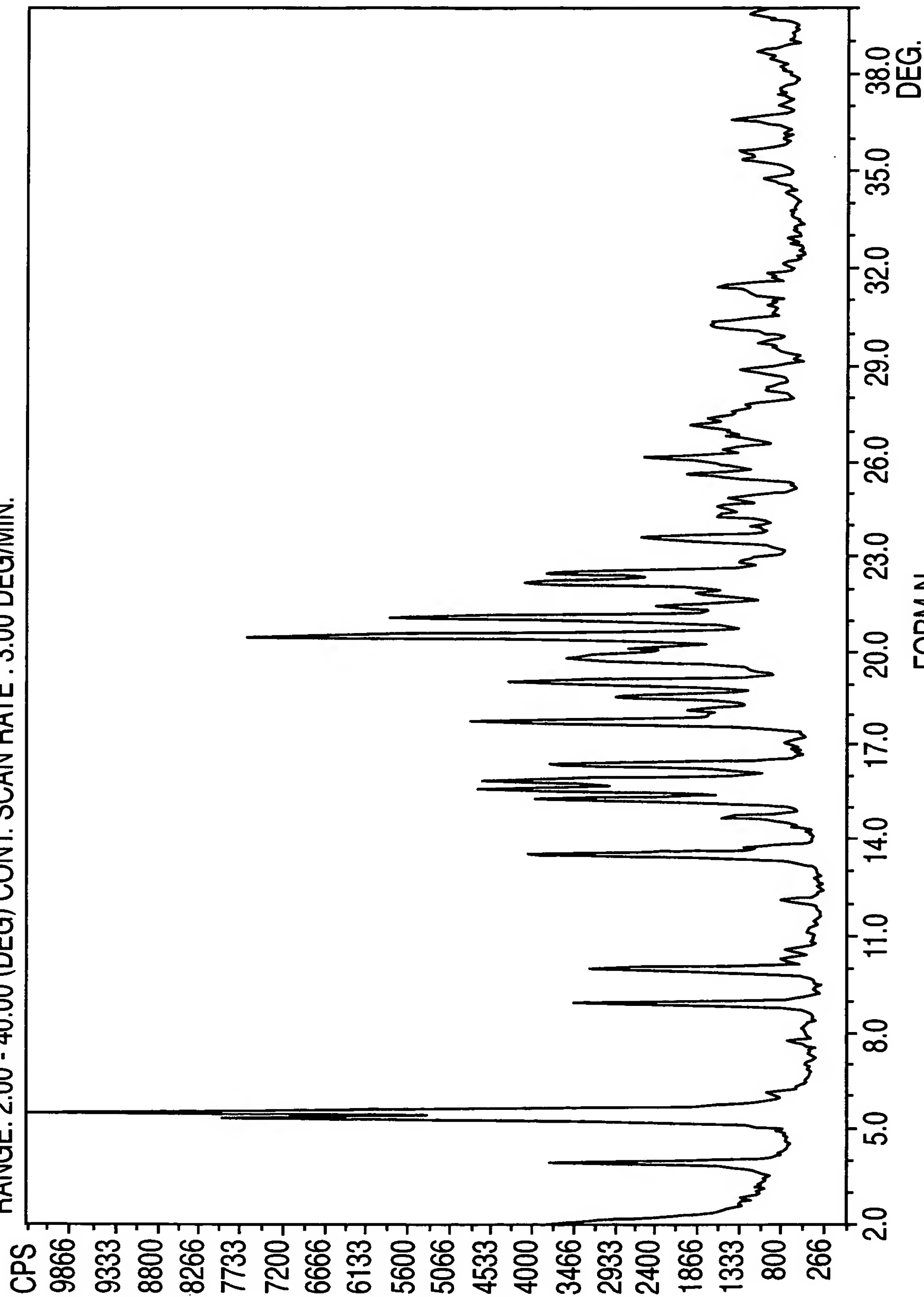
STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM M

FIG. 11

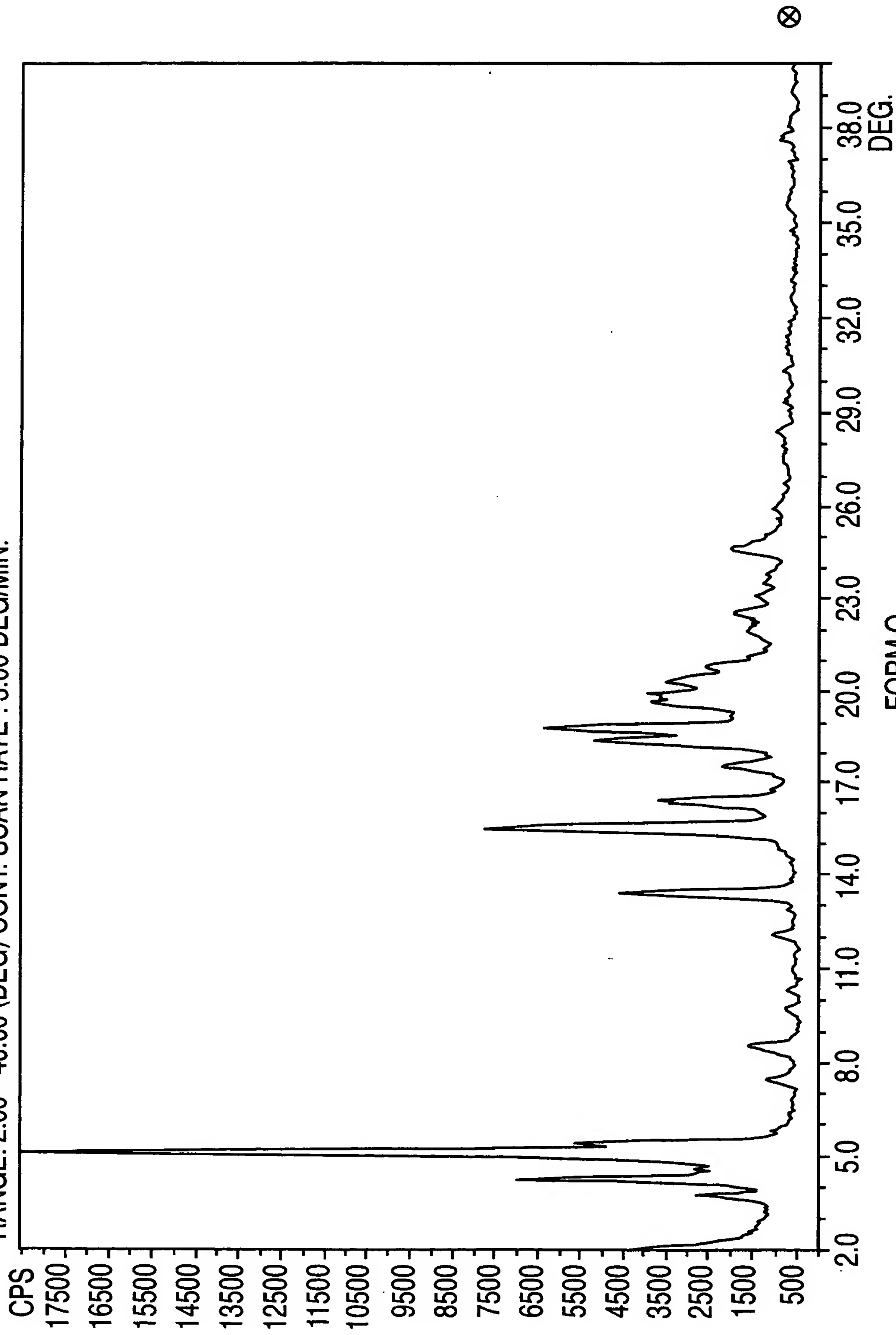
STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



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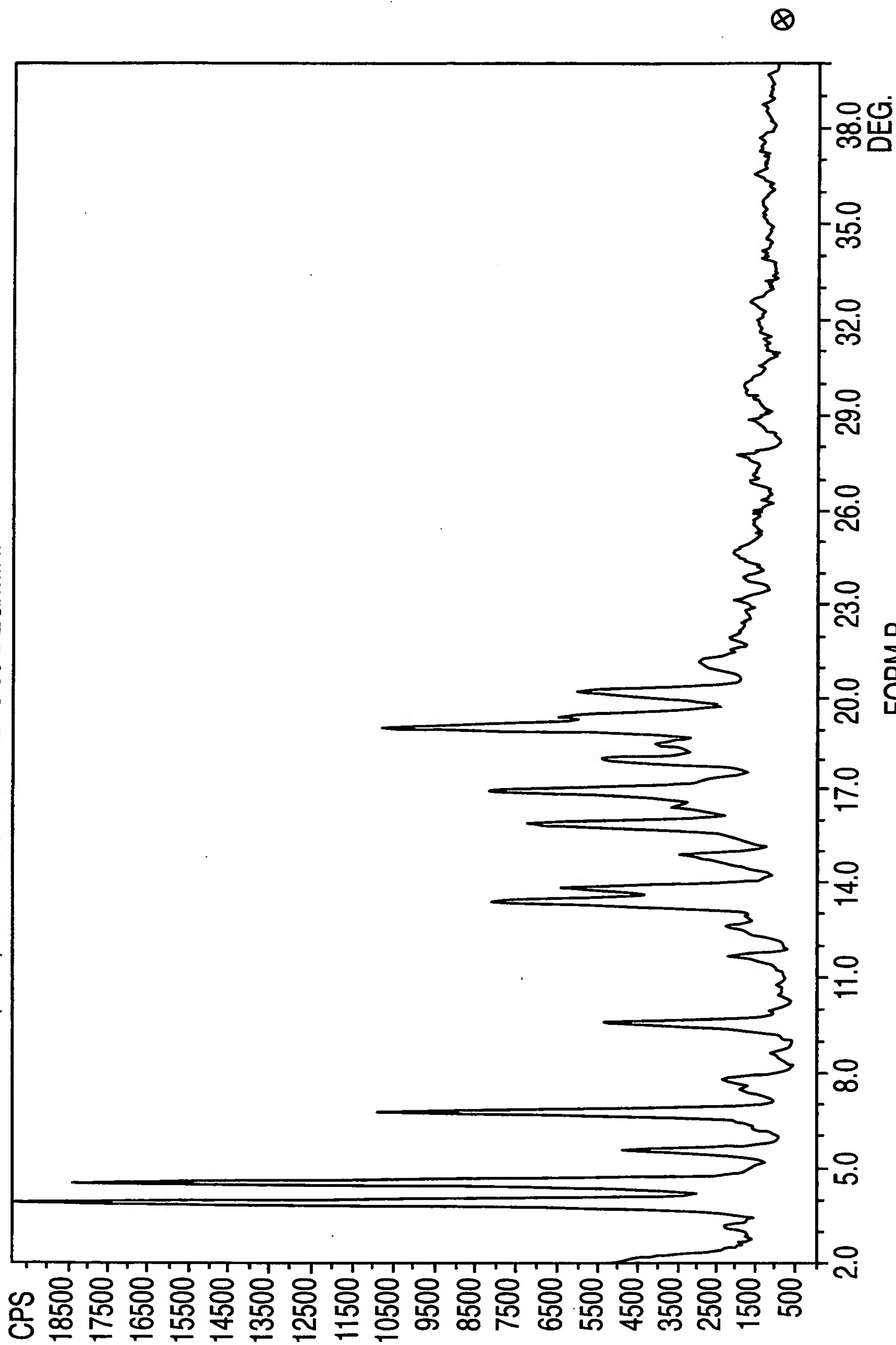
FORM N
FIG. 12

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM O
FIG. 13

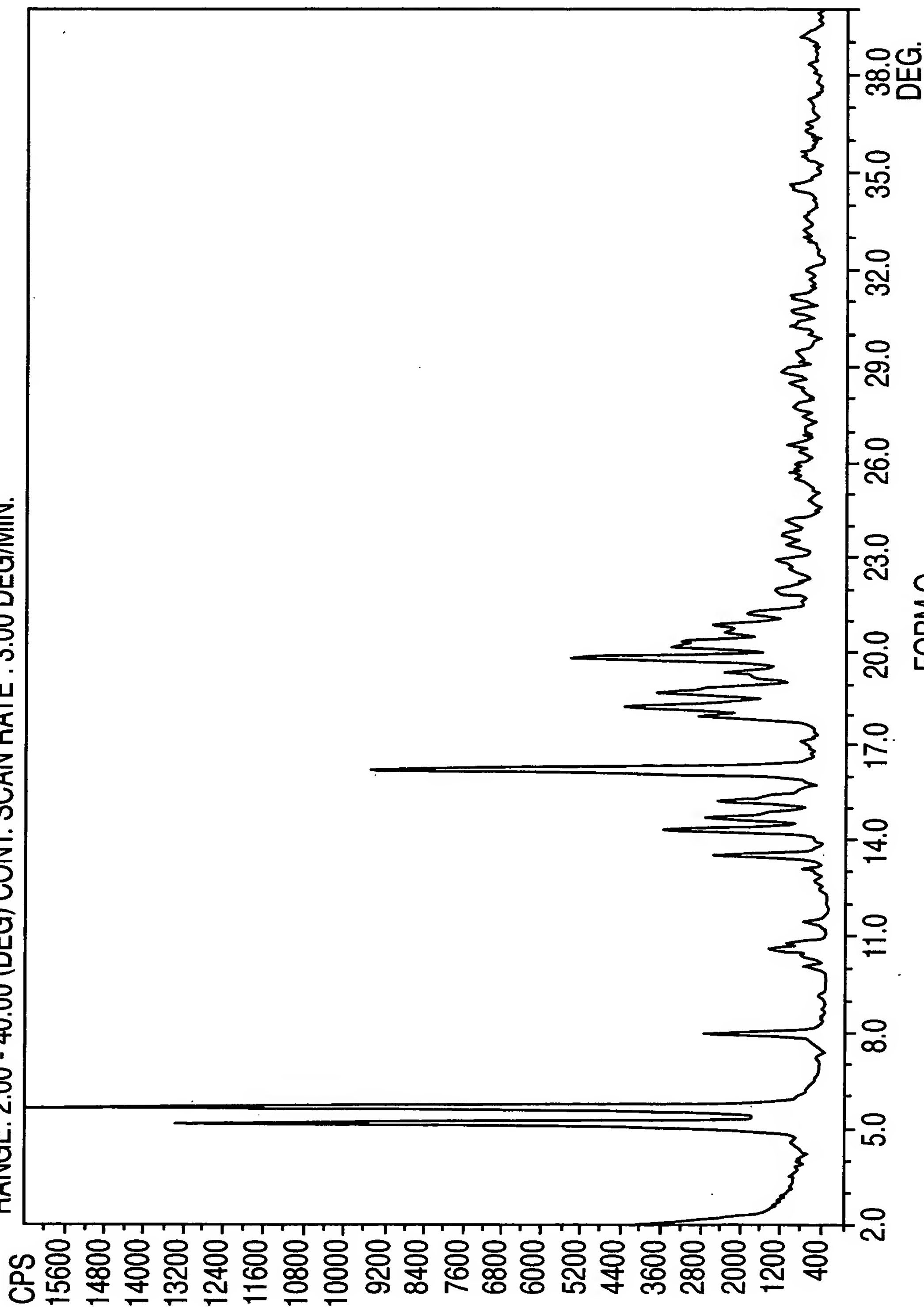
STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM P

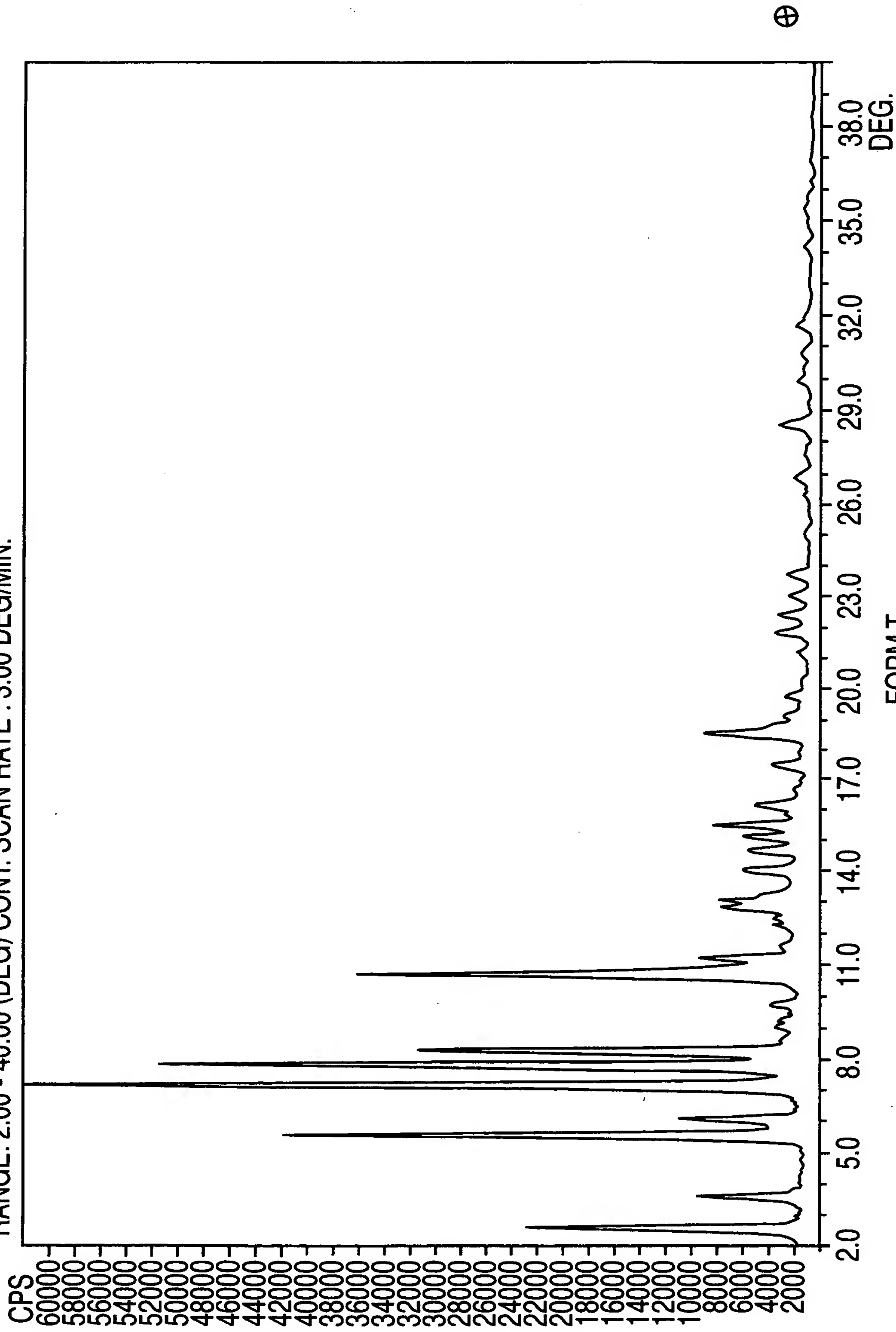
FIG. 14

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



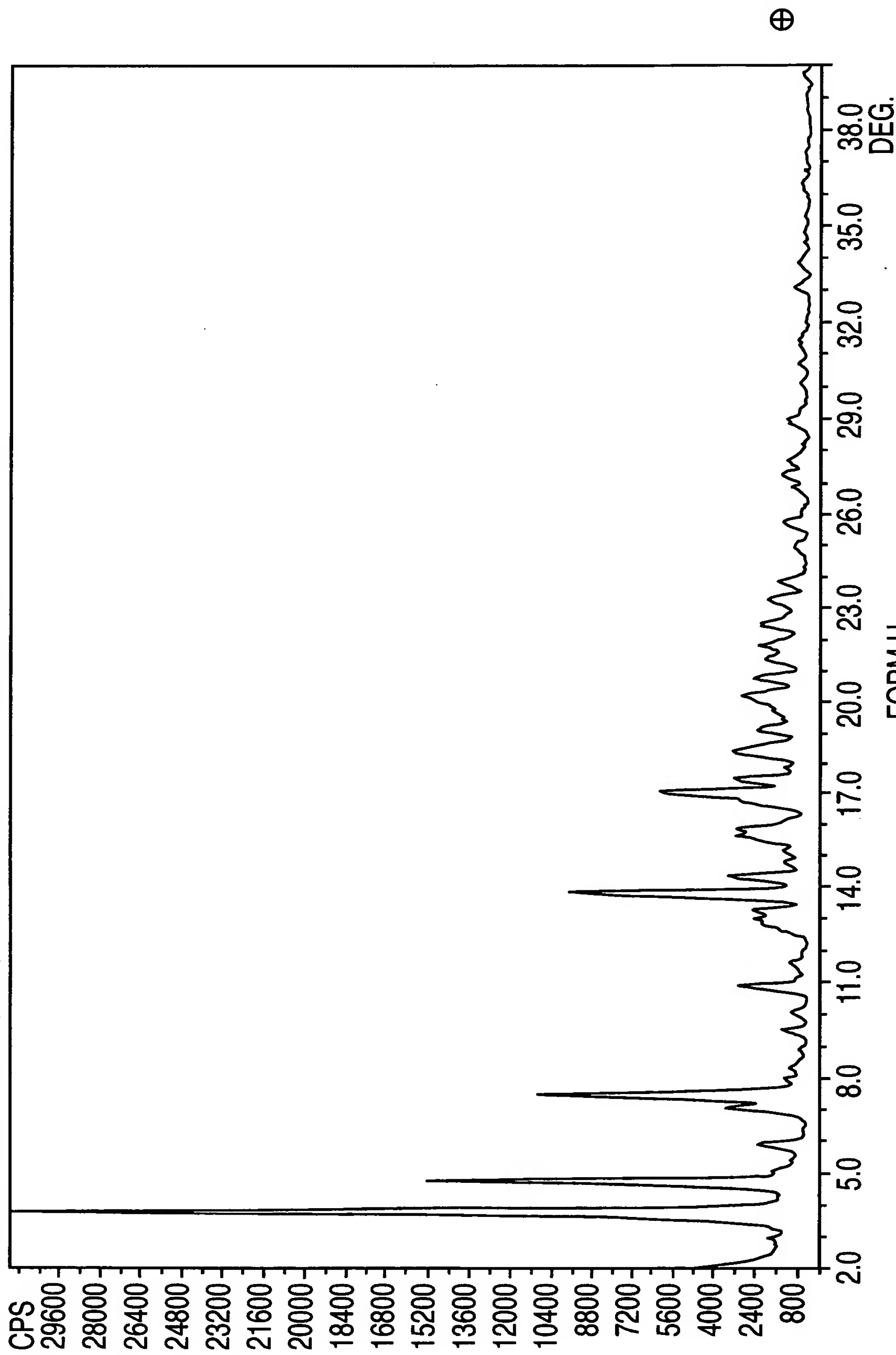
FORM Q
FIG. 15

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

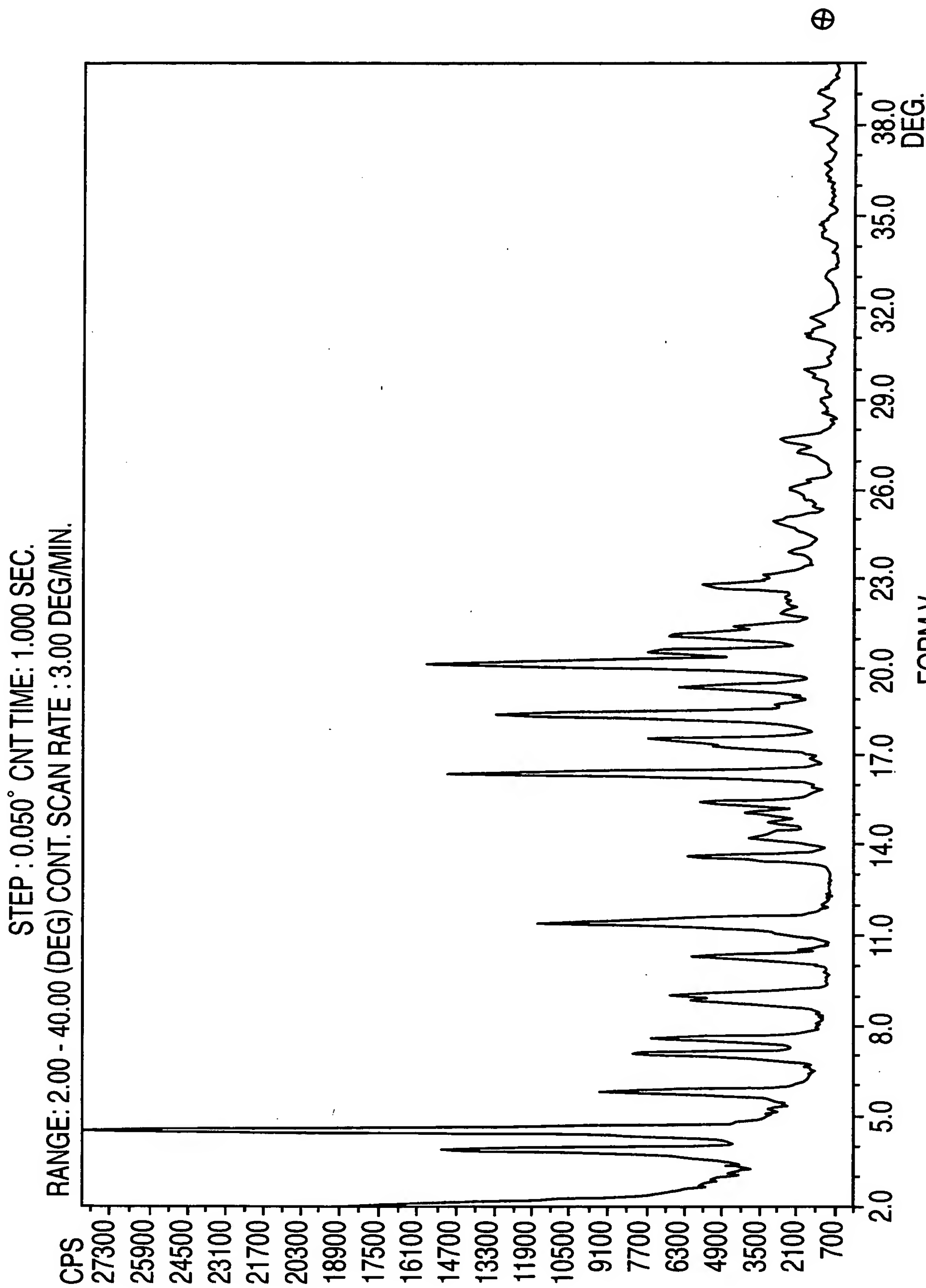


FORM T
FIG. 16

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



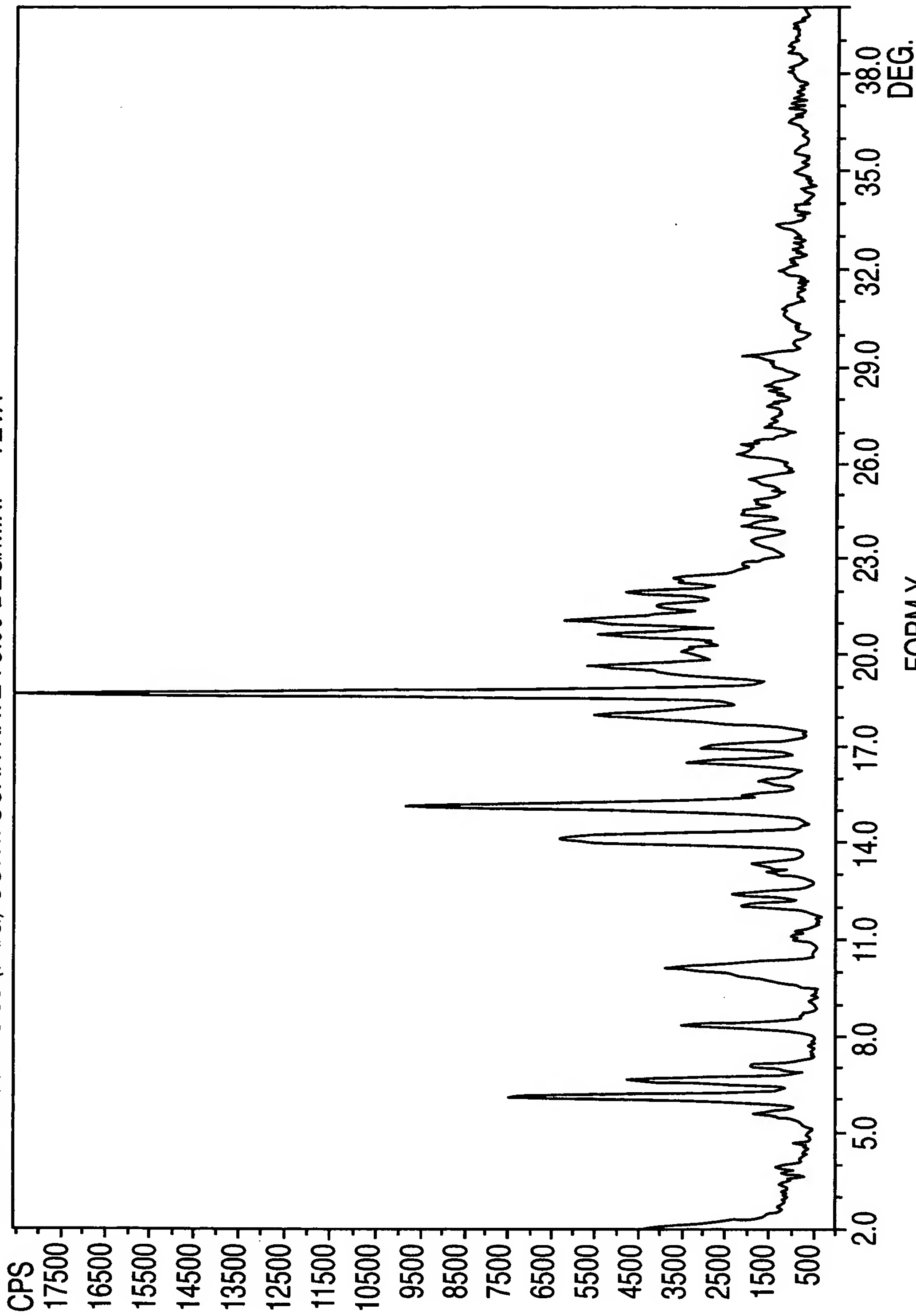
FORM U
FIG. 17



FORM V
 FIG. 18

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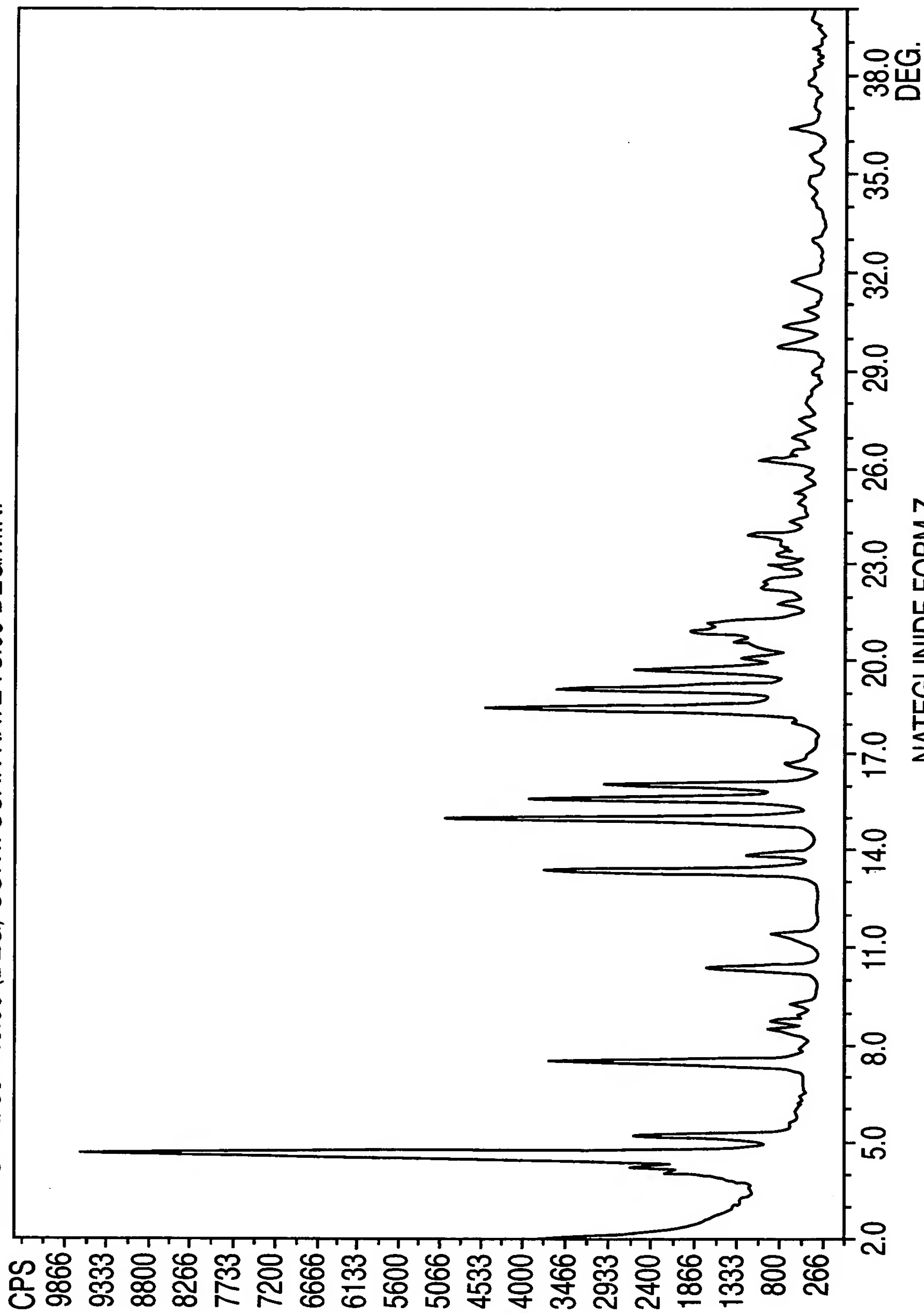
STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN. TEVA



FORM Y

FIG. 19

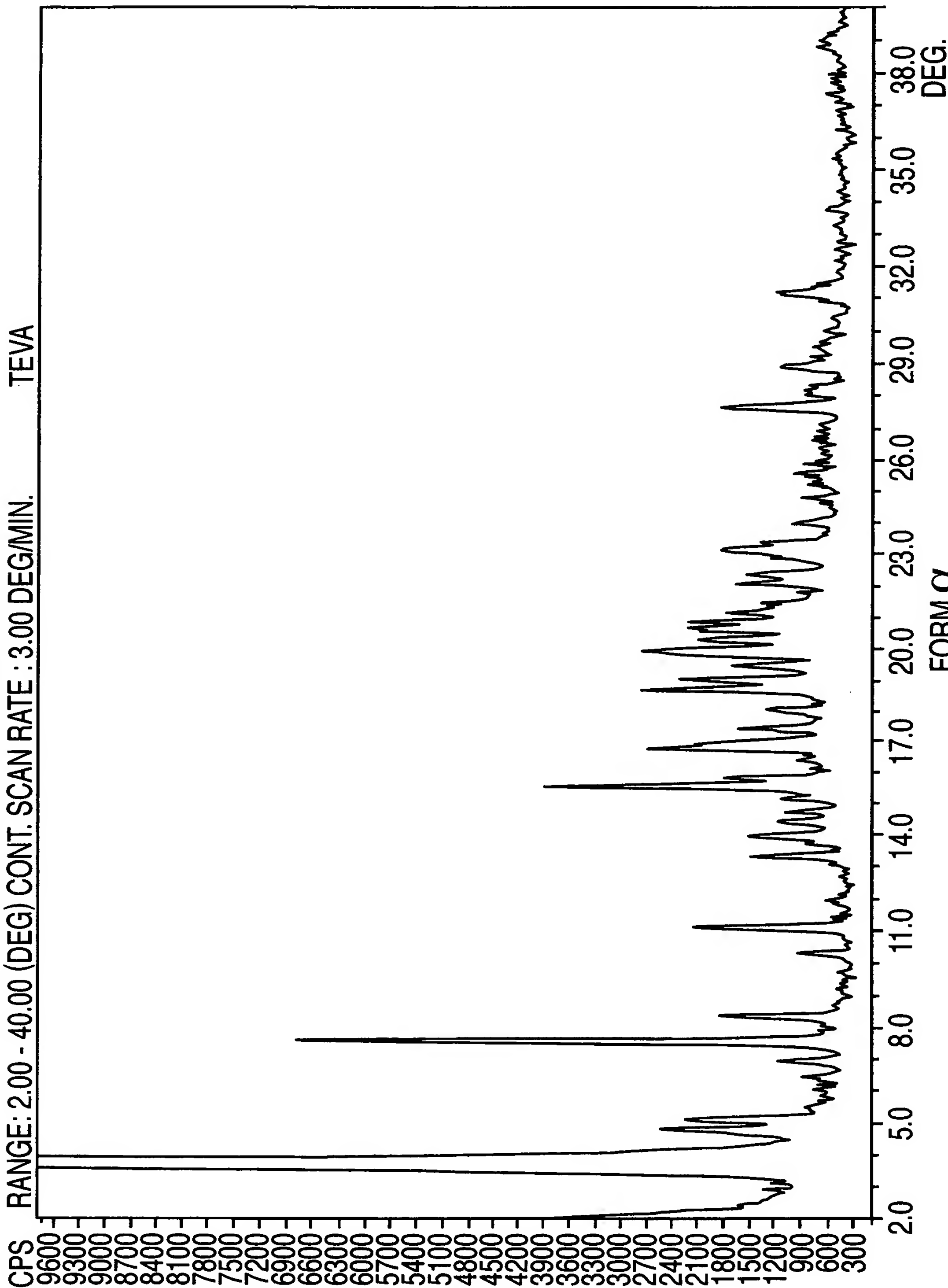
STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



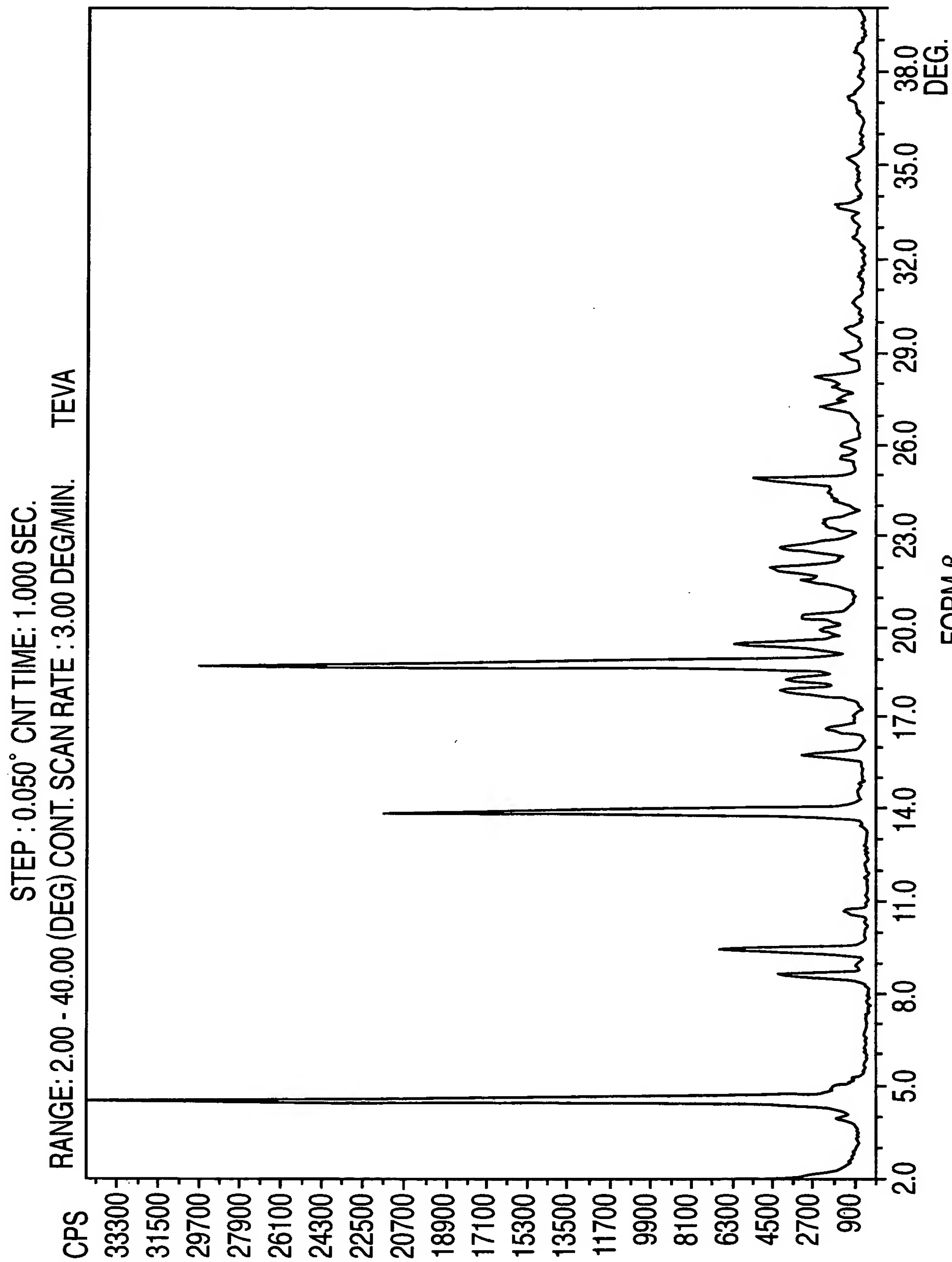
NATEGLINIDE FORM Z

FIG. 20

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN. TEVA

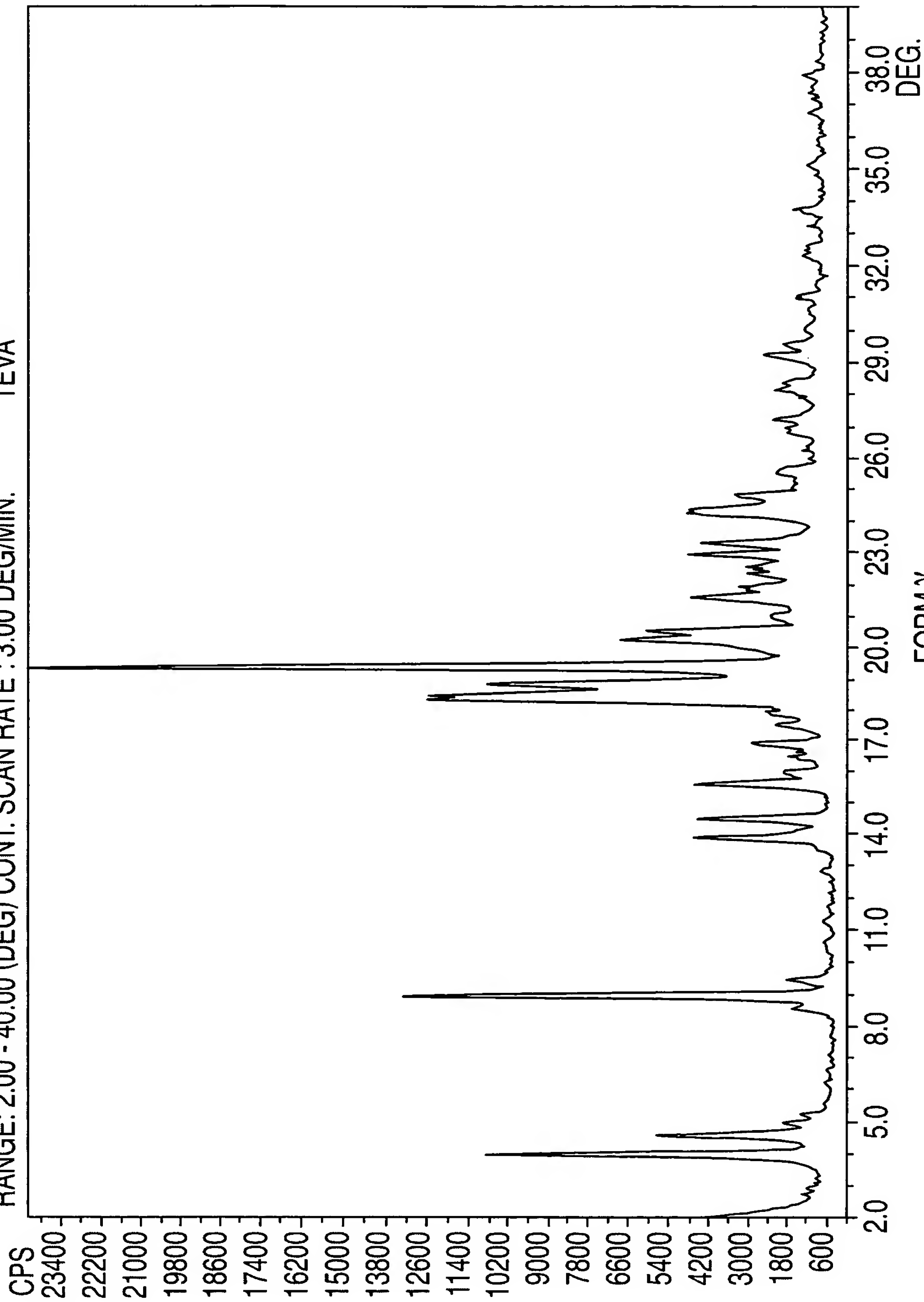


FORM α
FIG. 21



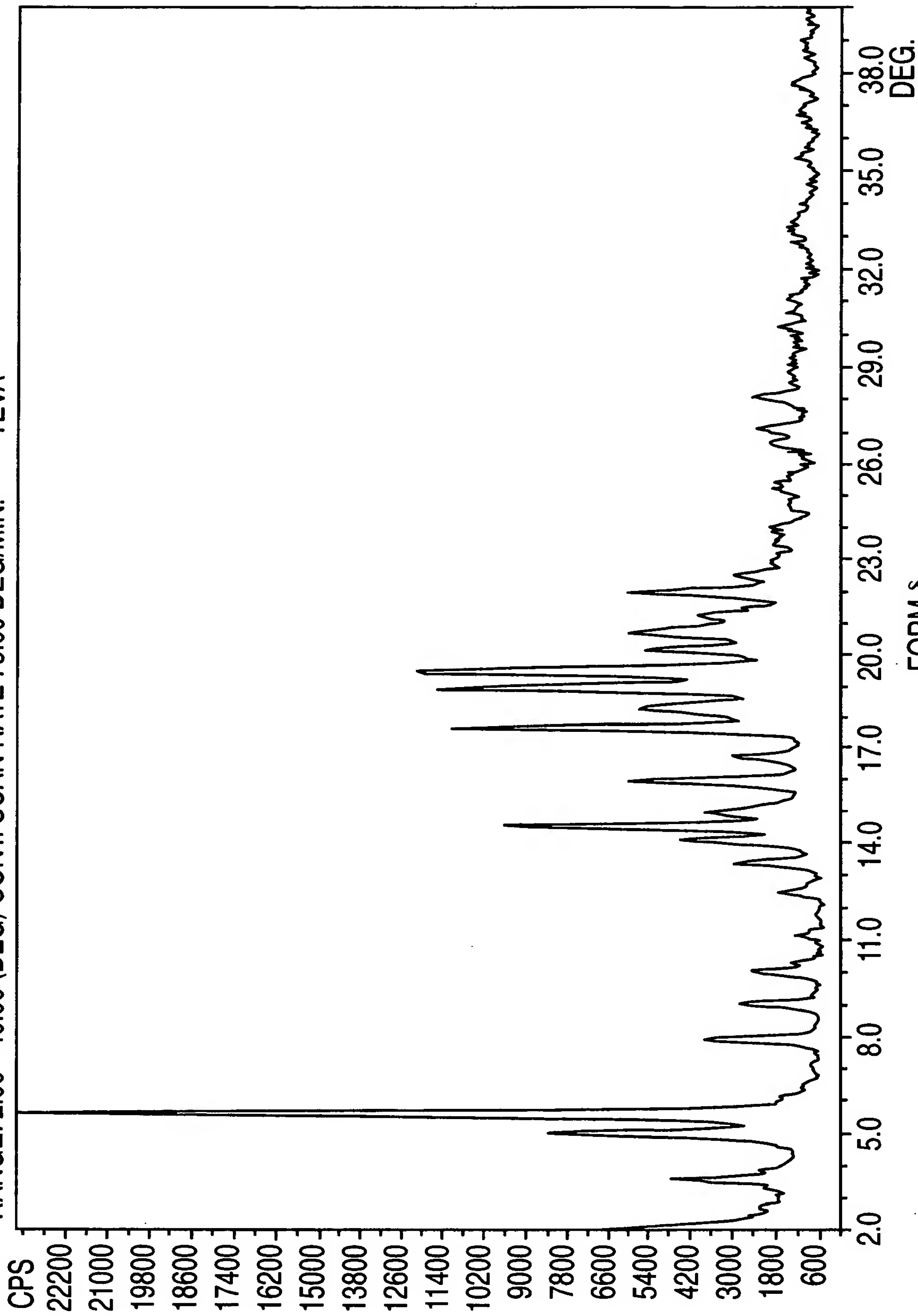
FORM β
FIG. 22

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN. TEVA



FORM γ
FIG. 23

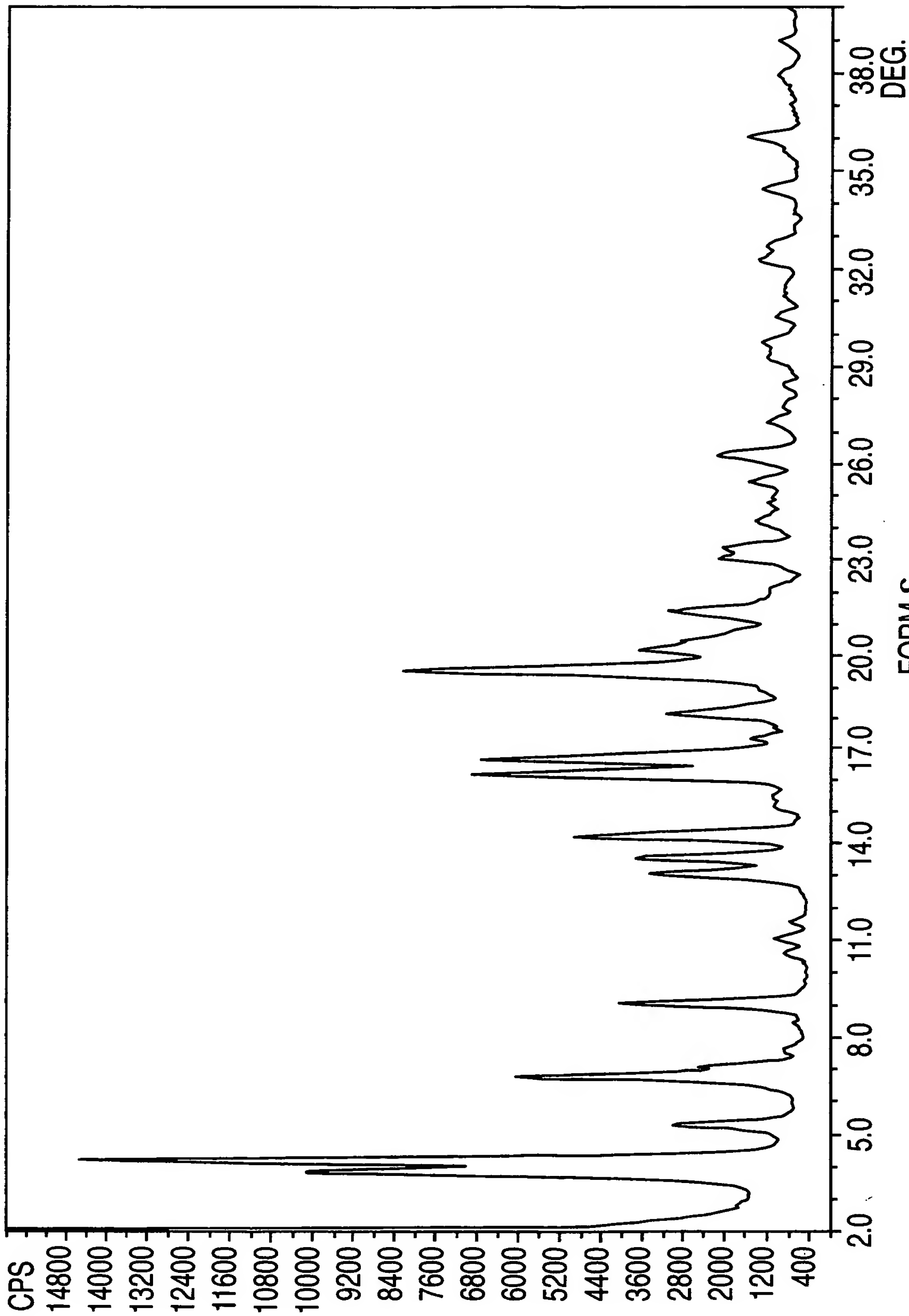
STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN. TEVA



FORM δ

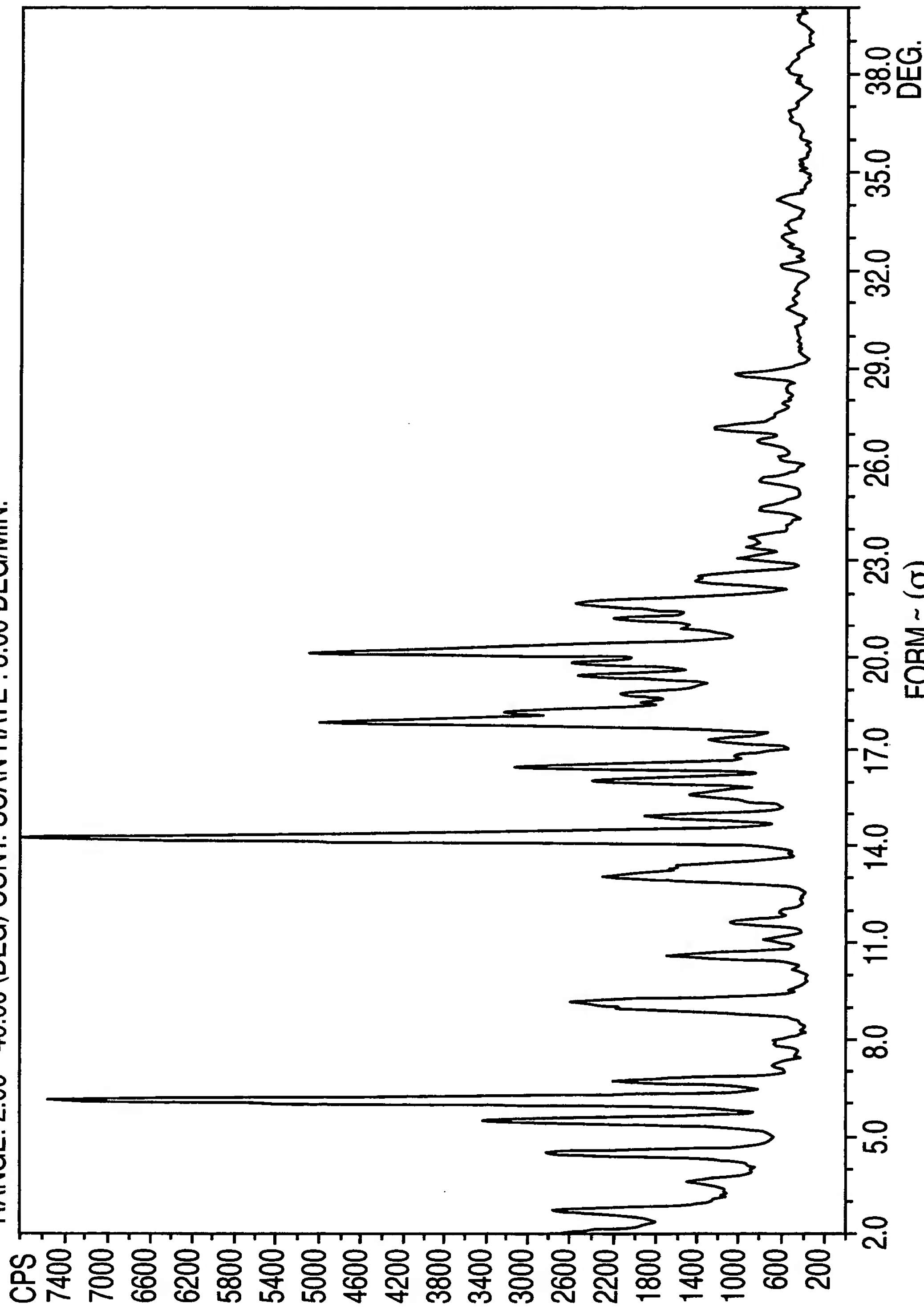
FIG. 24

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN. TEVA



FORM E
FIG. 25

SIGMA STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM ~ (σ)

FIG. 26

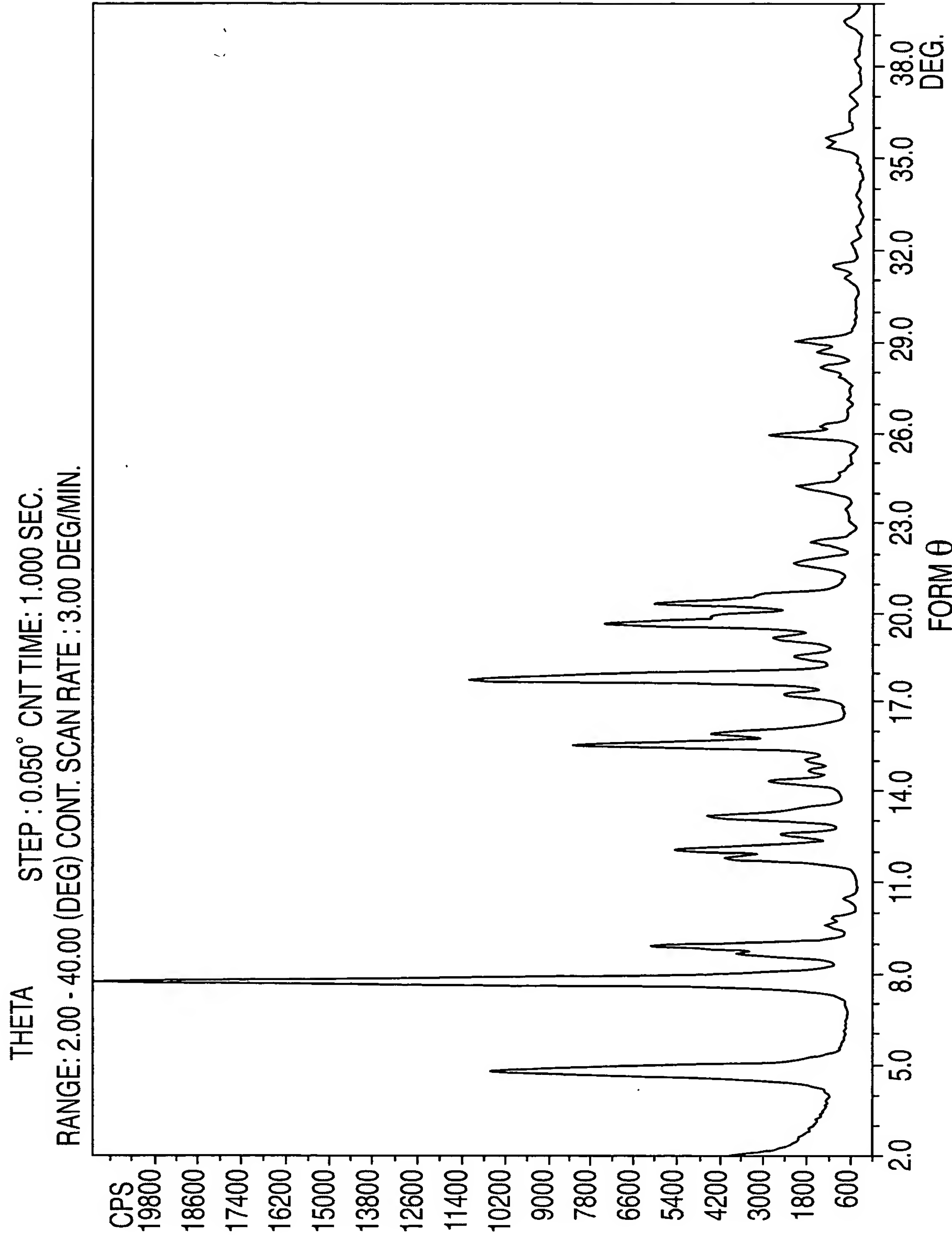
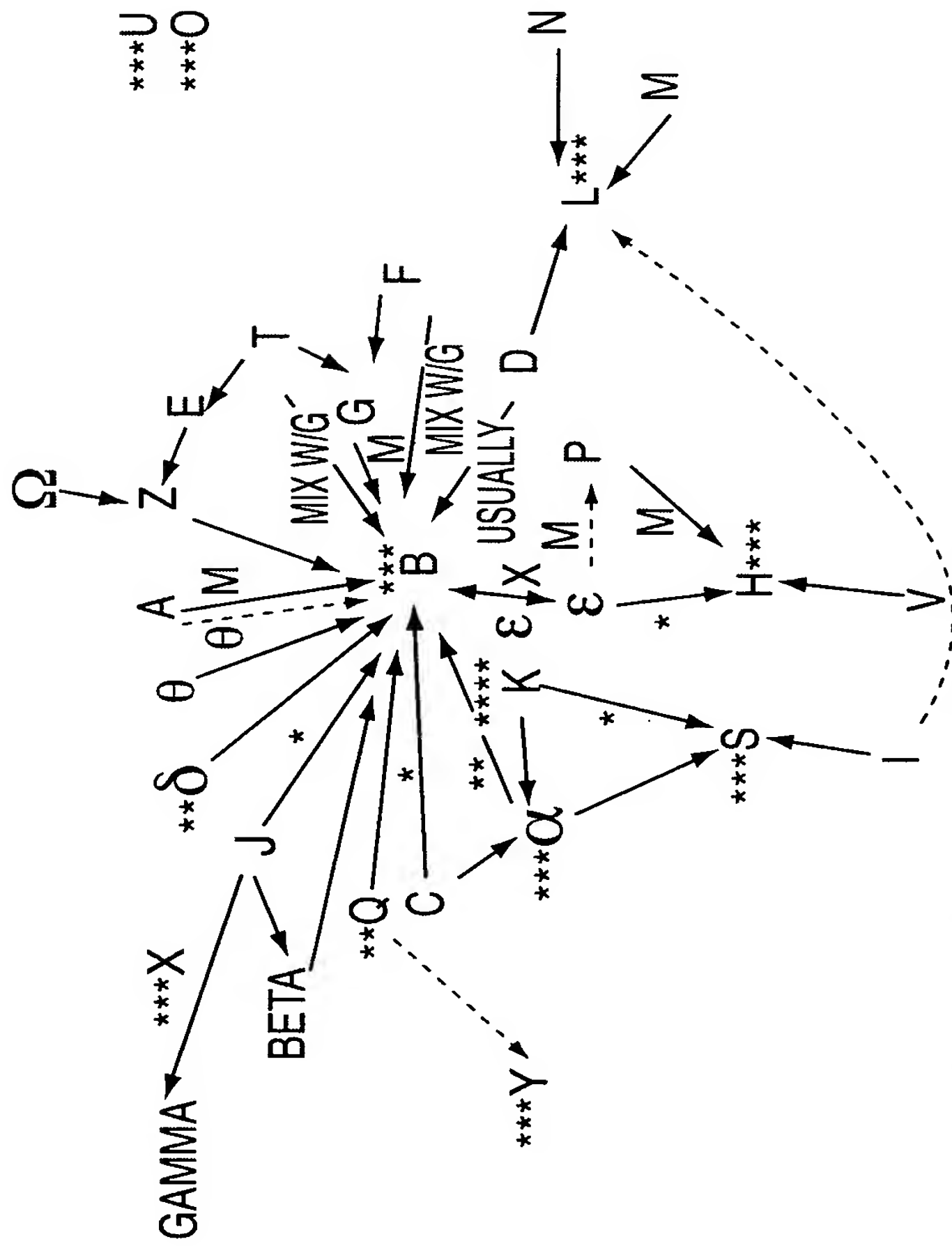


FIG. 27



- * TRANSFORMATION MAY PROCEED THROUGH ANOTHER TERM.
- ** THERMALLY STABLE AT LOWER HEATING TEMPERATURES (~50°C).
- *** THERMALLY STABLE FORMS.
- > TRANSFORMATION AFTER STORAGE AT ROOM TEMPERATURE.
- m MIXTURE WITH STARTING FORM.
- **** WHEN STARTING MATERIAL CONTAINS SEEDS.
- sol RESULTS MIGHT VARY DEPENDING ON THE SOLVATE OF FORM EPSILON USED.

THERMAL STABILITY CHART

FIG. 28

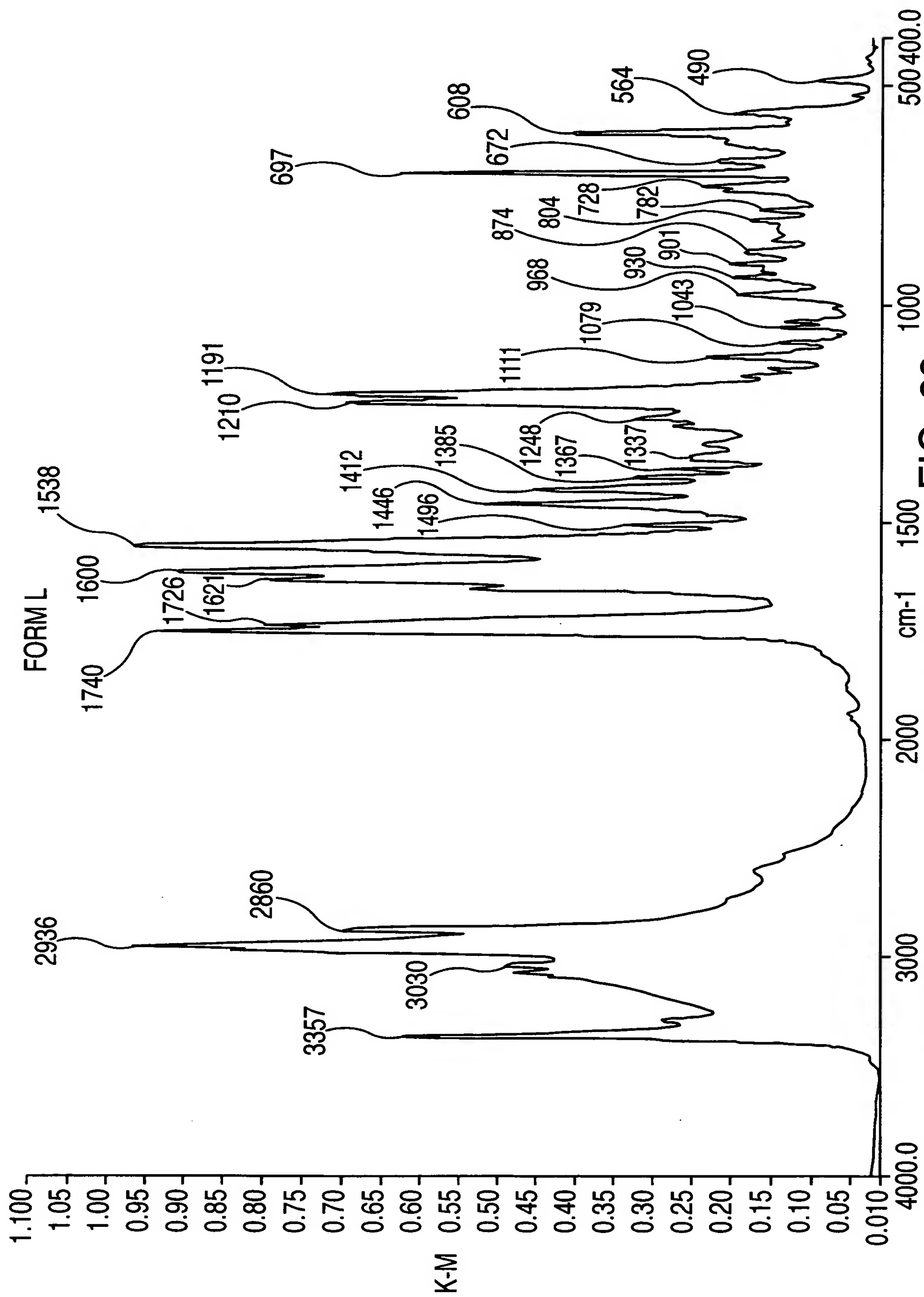
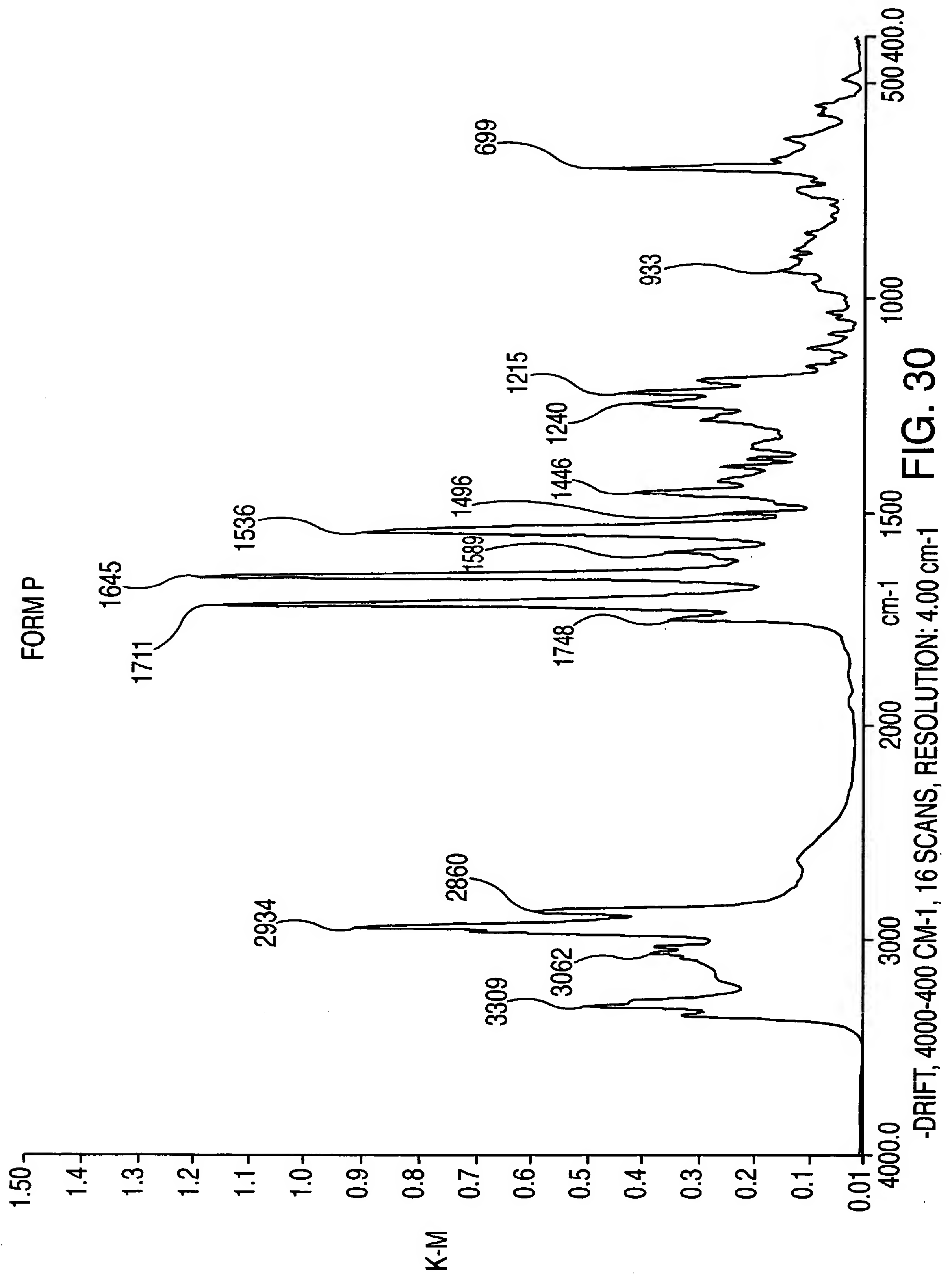
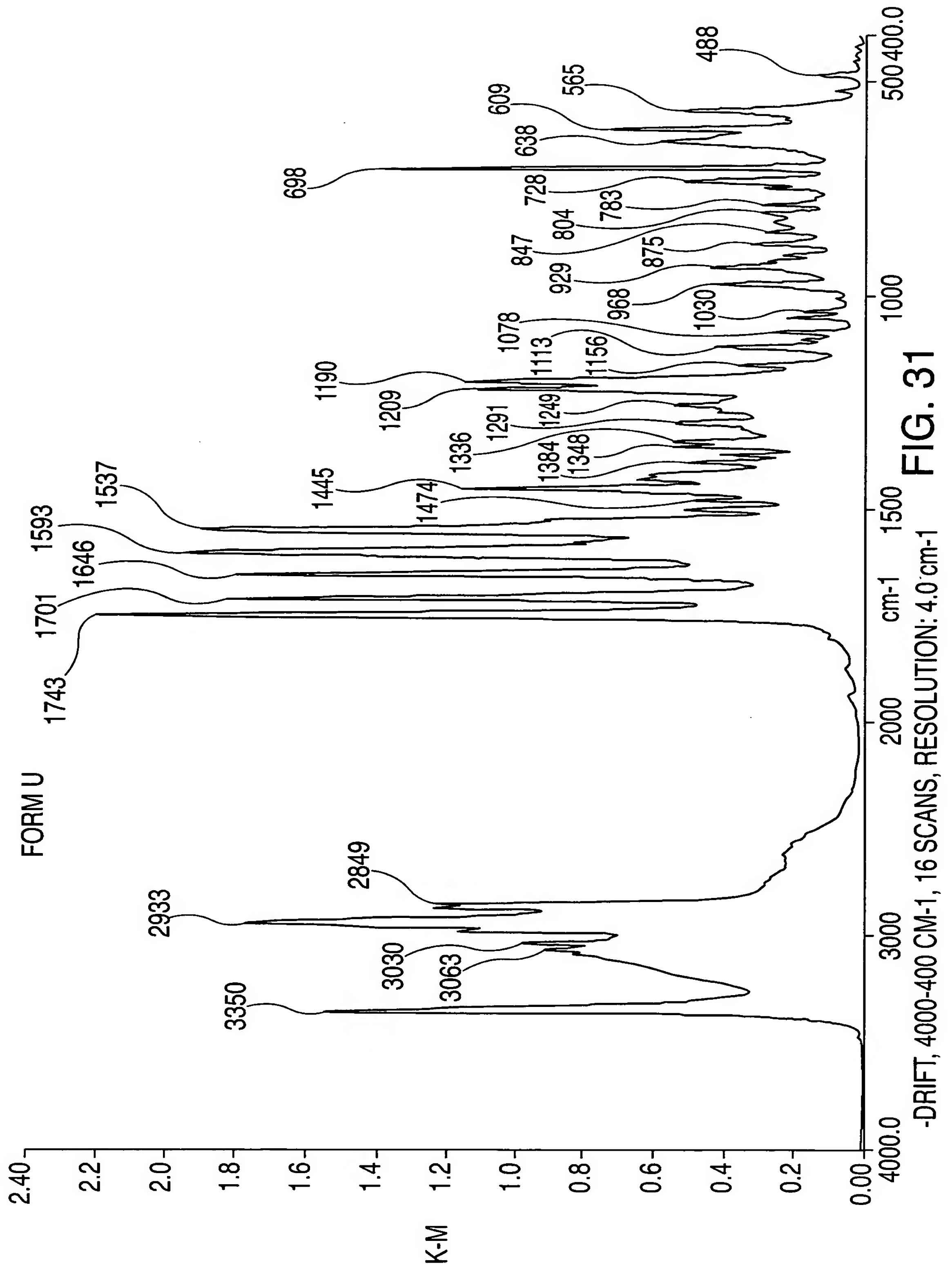
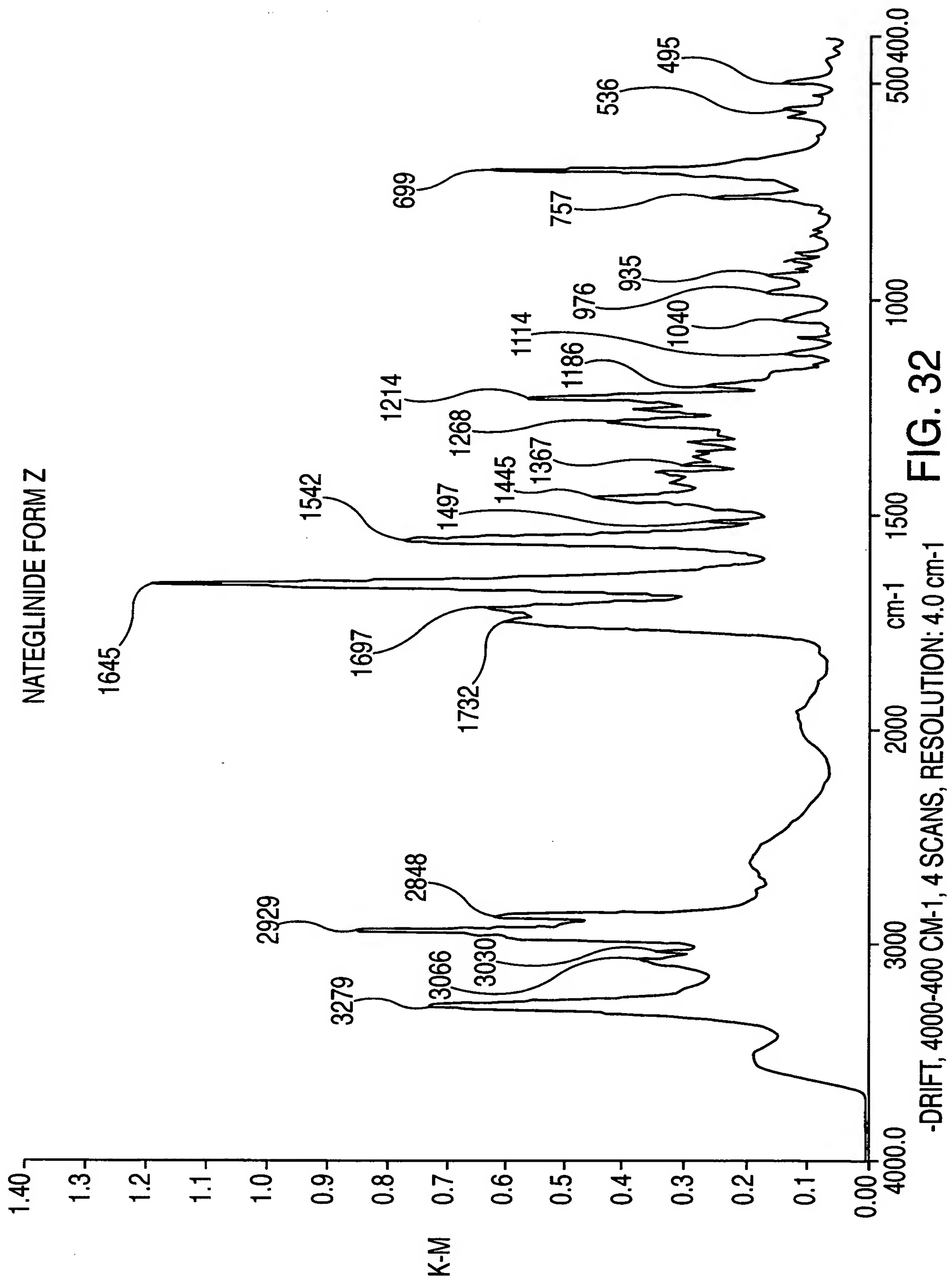


FIG. 29

-DRIFT, 4000-400 CM-1, 16 SCANS, RESOLUTION: 4.00 CM-1







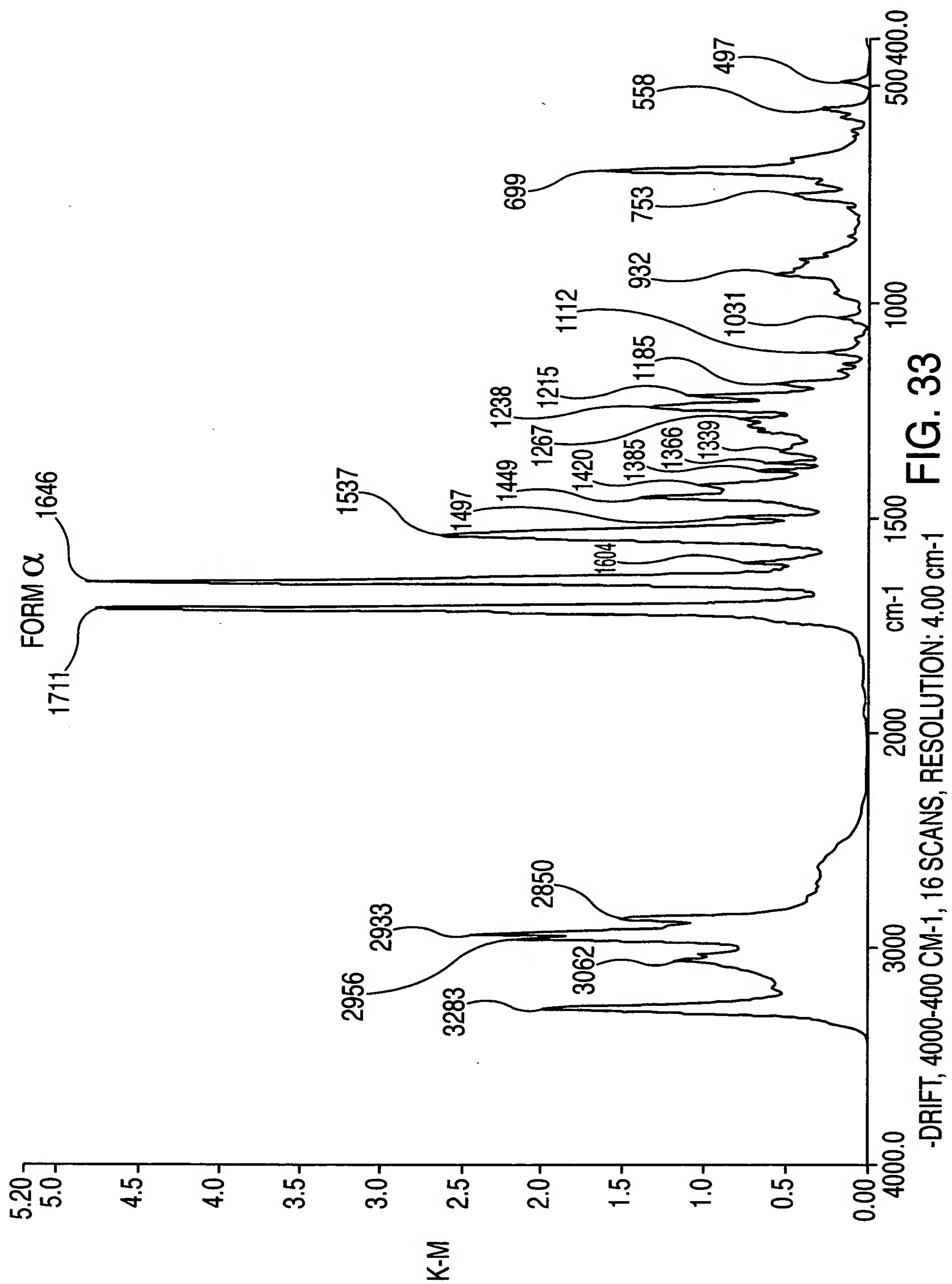
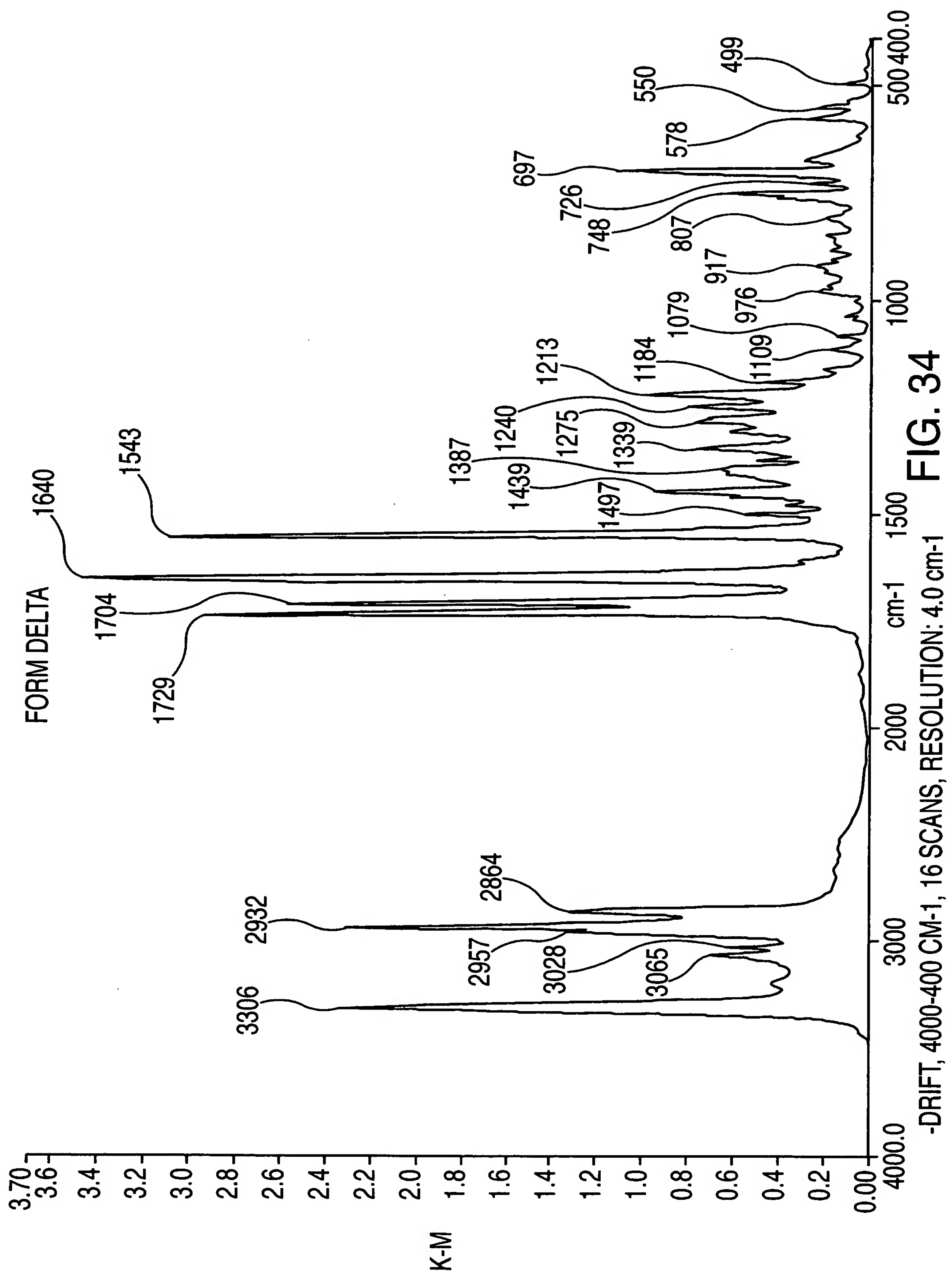


FIG. 33

-DRIFT, 4000-400 CM-1, 16 SCANS, RESOLUTION: 4.00 CM-1



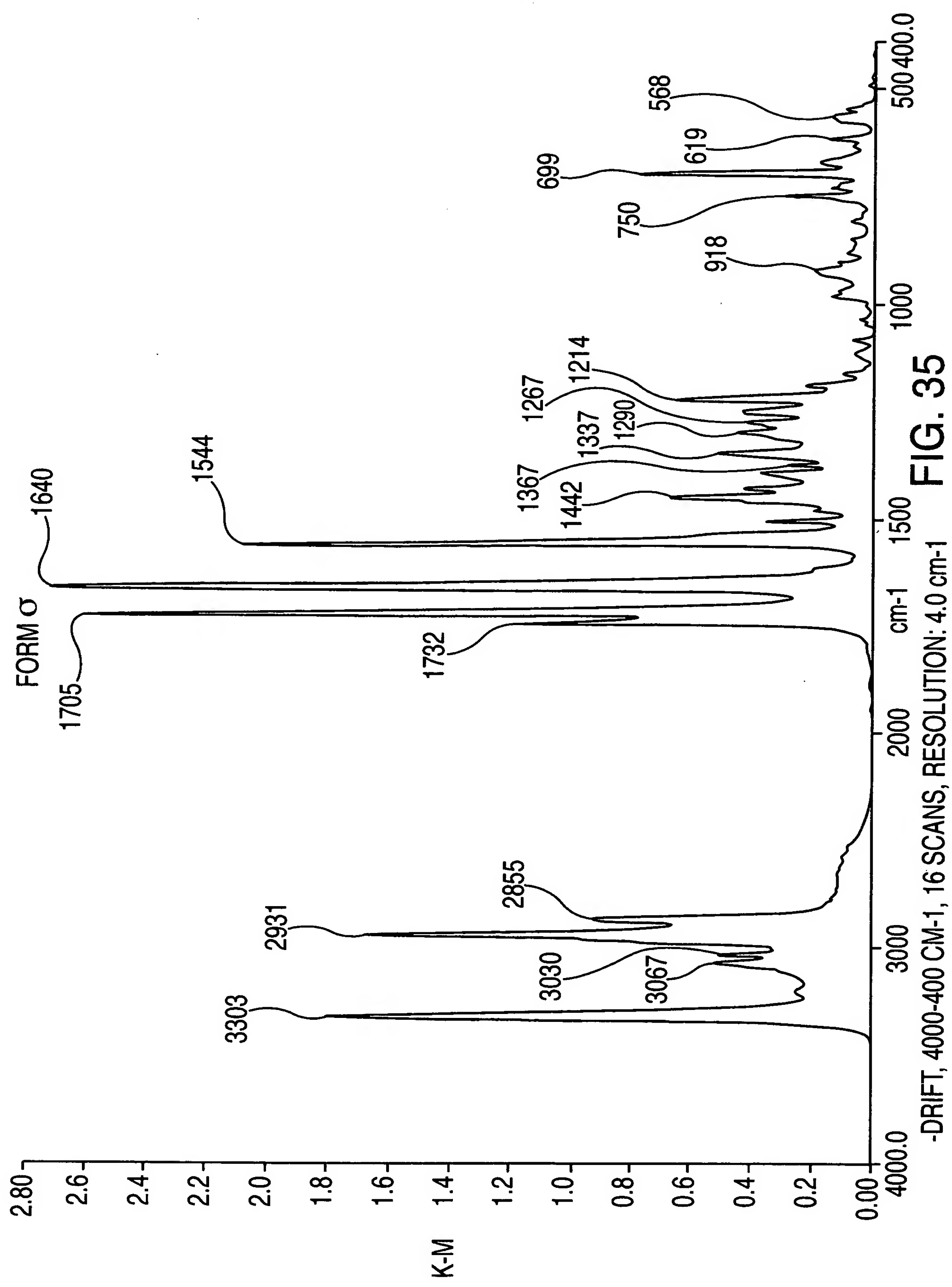
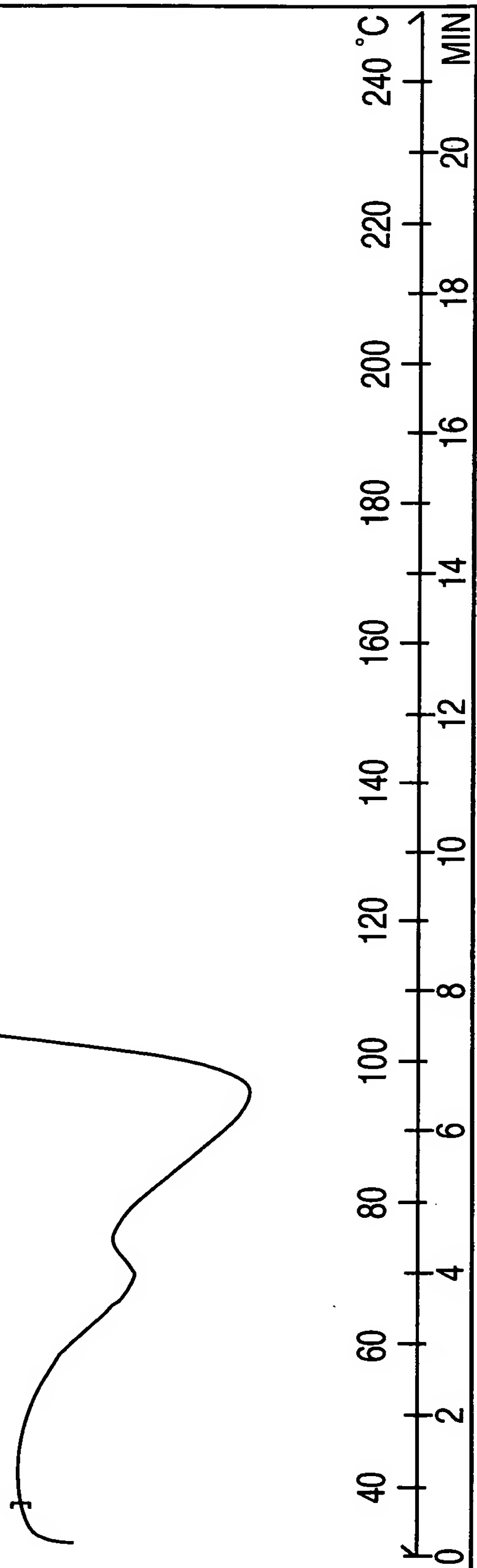


FIG. 35

^EXO

METHOD: 30-250C, 10C/MIN, 40ML/MIN N2
30.0-250.0°C 10.00°C/MIN N2, 40.0 ML/MIN

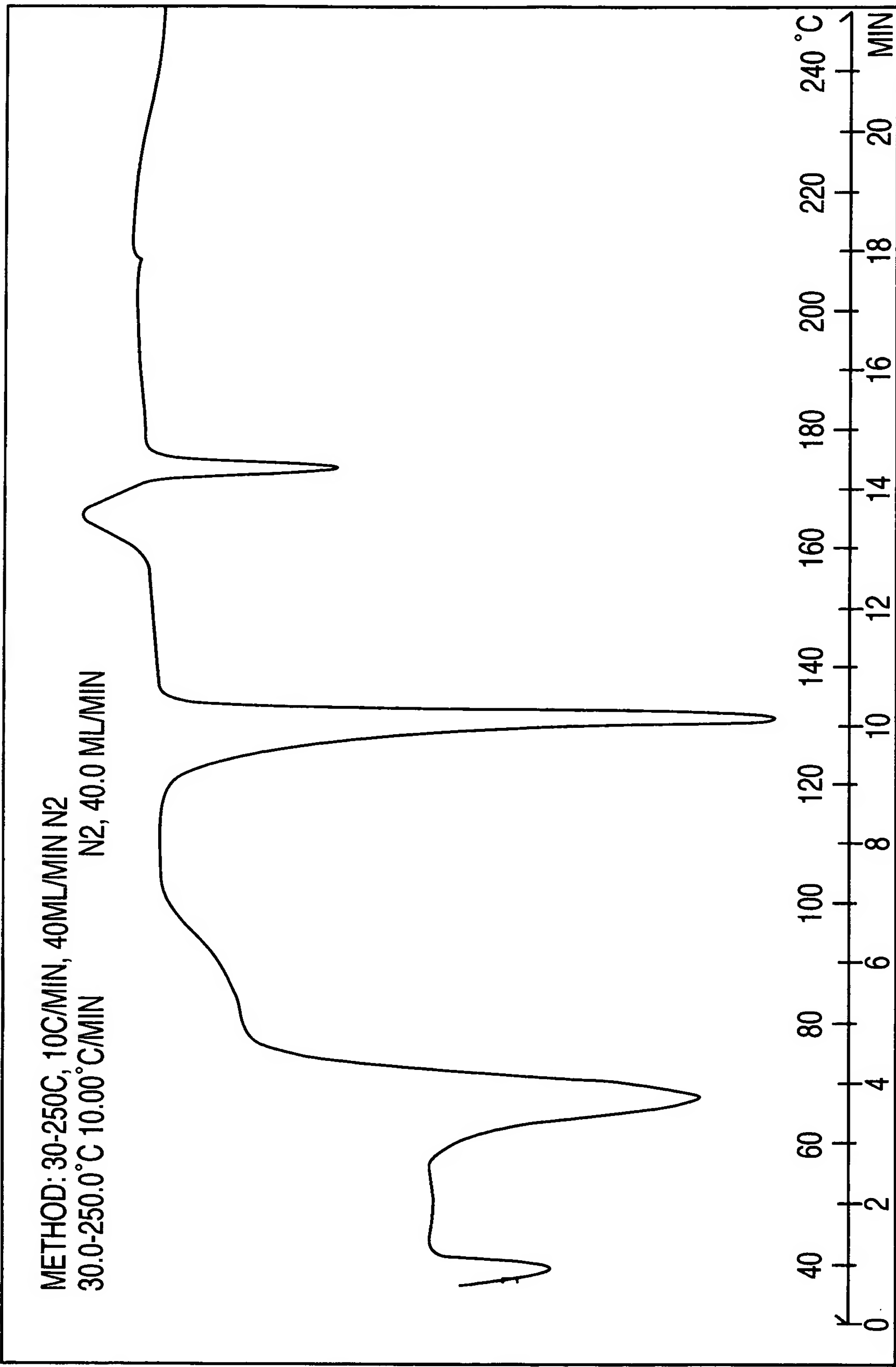


METTLER TOLEDO STAR^e SYSTEM

FORM A

FIG. 36

^EXO



METTLER TOLEDO STAR^e SYSTEM

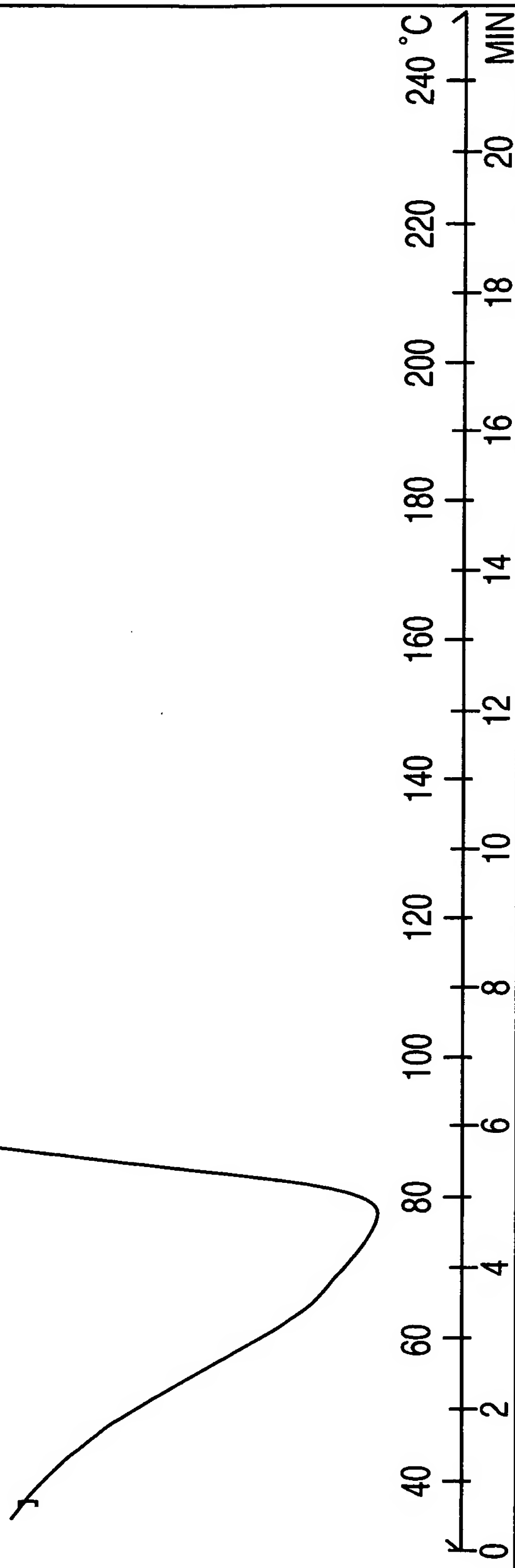
FORM D

FIG. 37

^EXO

METHOD: 30-250C, 10C/MIN, 40ML/MIN N2
30.0-250.0°C 10.00°C/MIN

N2, 40.0 ML/MIN

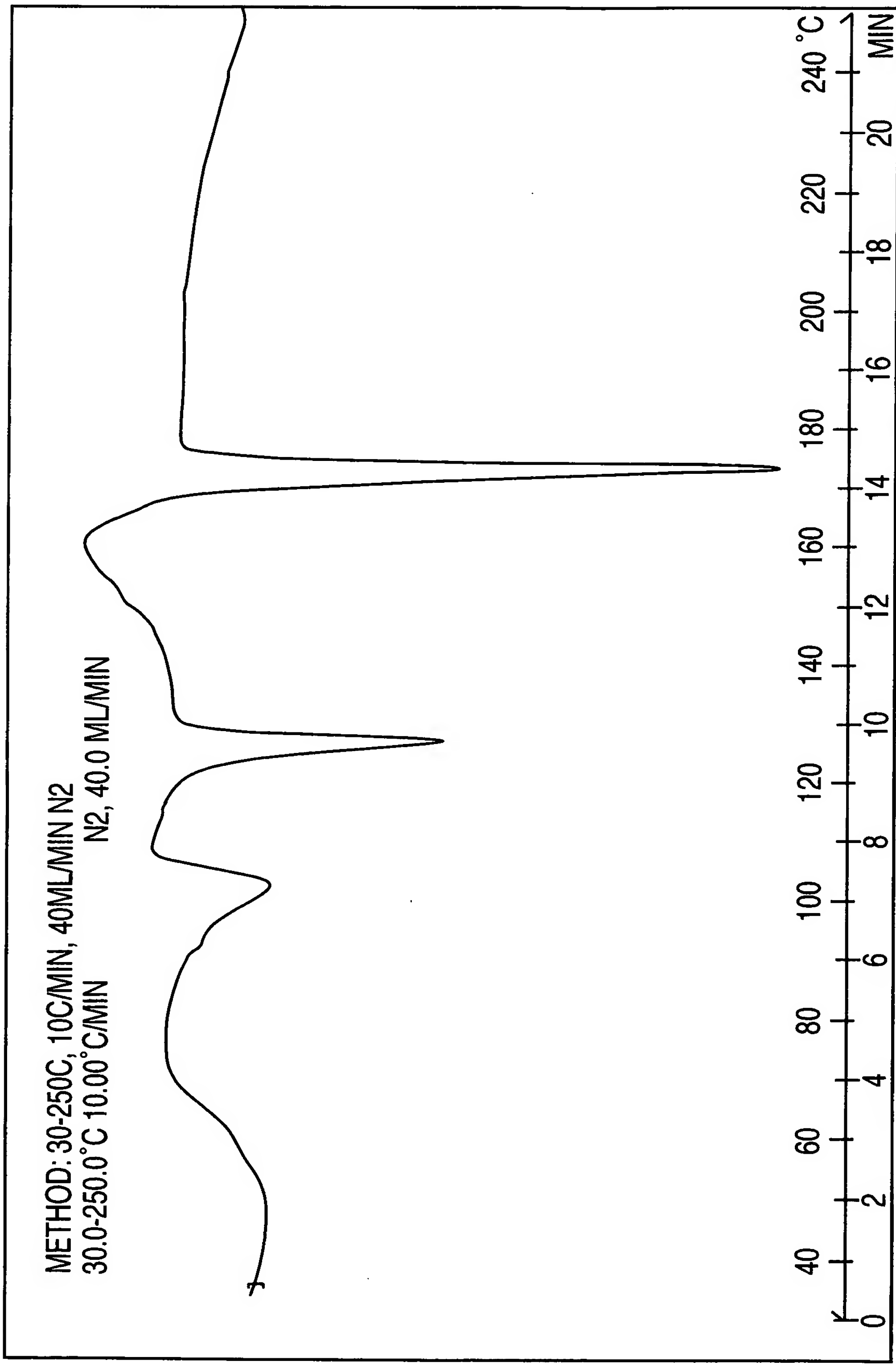


METTLER TOLEDO STAR^e SYSTEM

FORM E

FIG. 38

^EXO

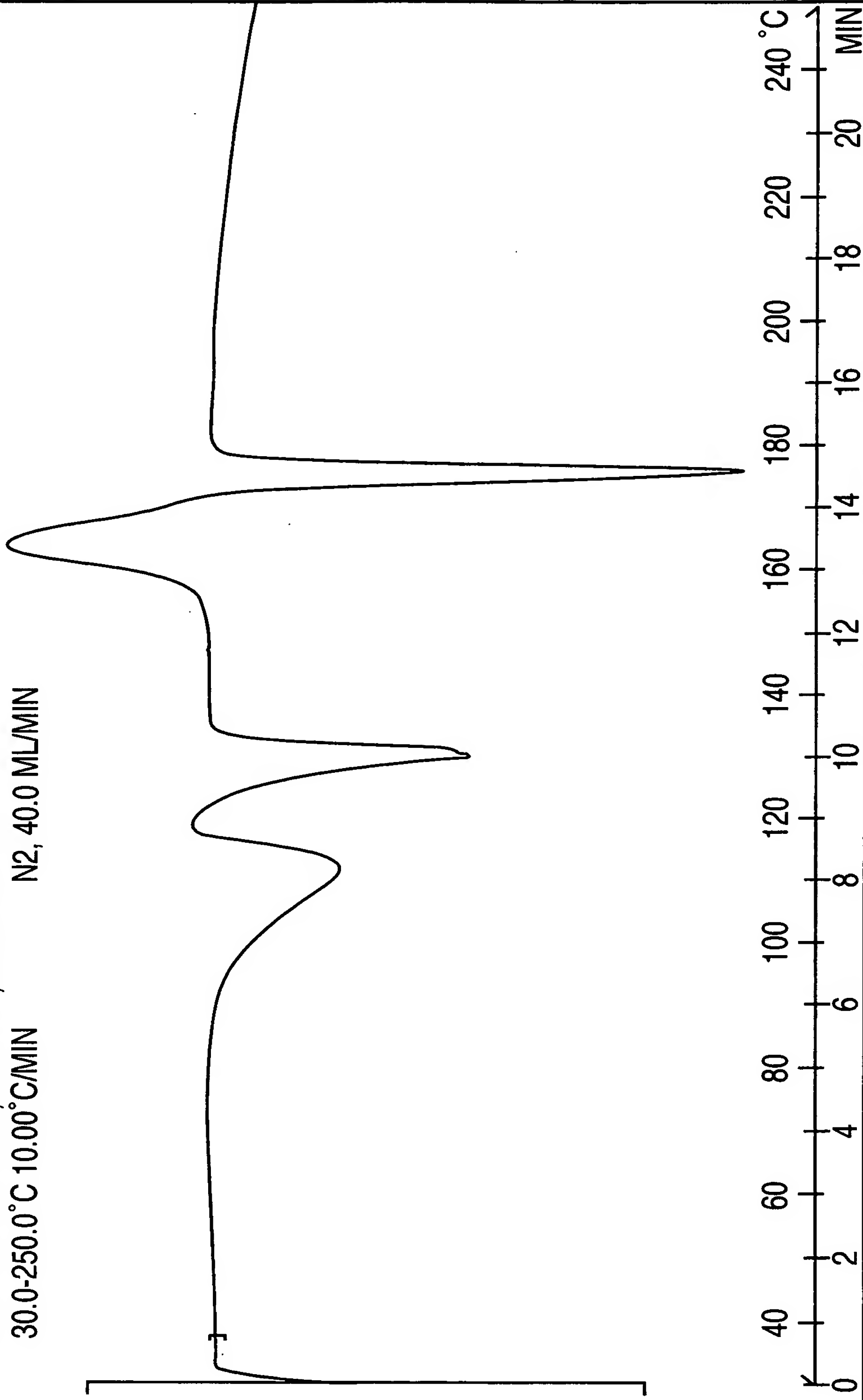


METTLER TOLEDO STAR^e SYSTEM

FIG. 39

^EXO

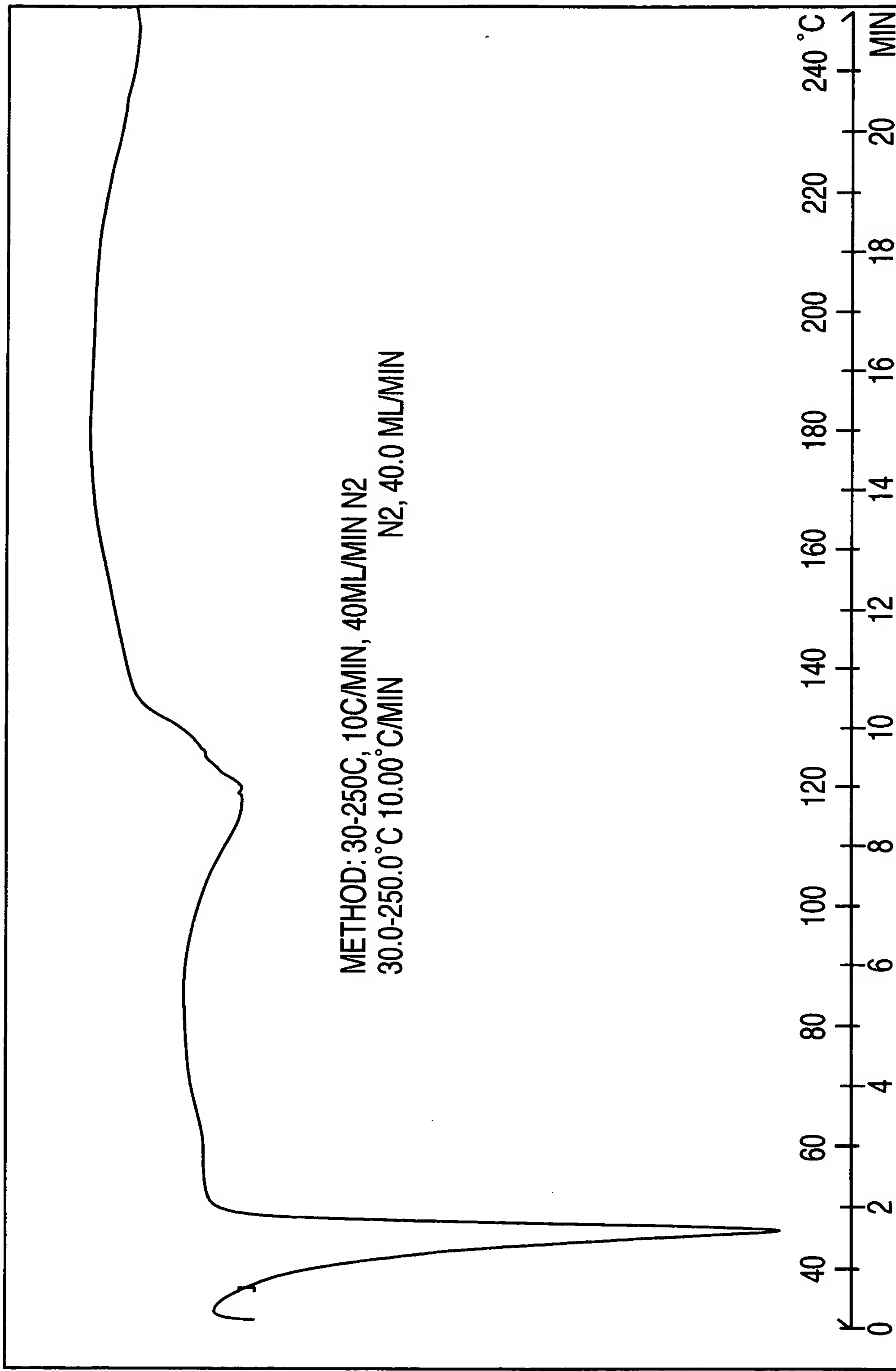
METHOD: 30-250C, 10C/MIN, 40ML/MIN N2
30.0-250.0°C 10.00°C/MIN N2, 40.0 ML/MIN



METTLER TOLEDO STAR® SYSTEM

FIG. 40

^EXO



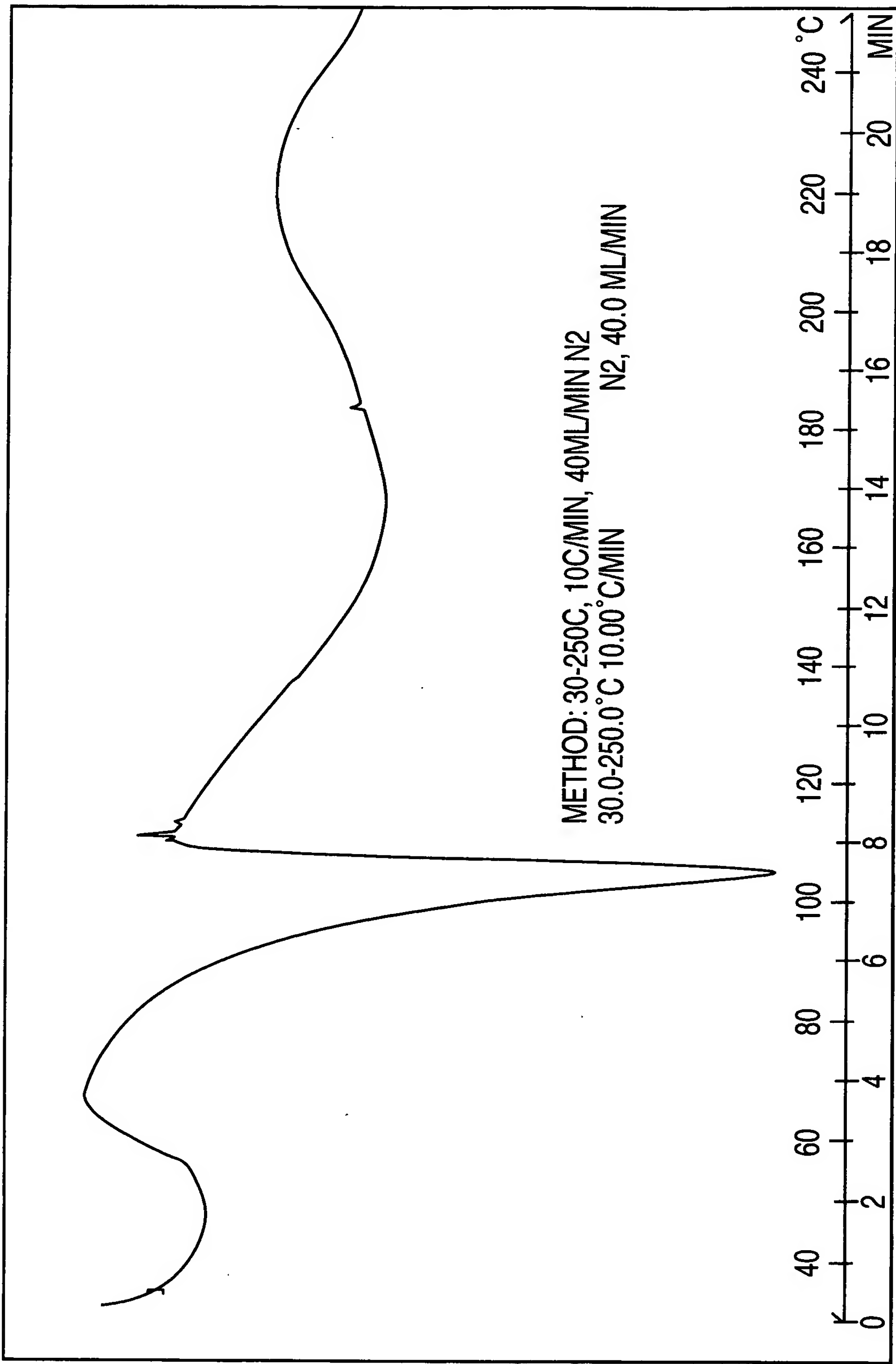
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METTLER TOLEDO STAR^e SYSTEM

FORM I

FIG. 41

^EXO

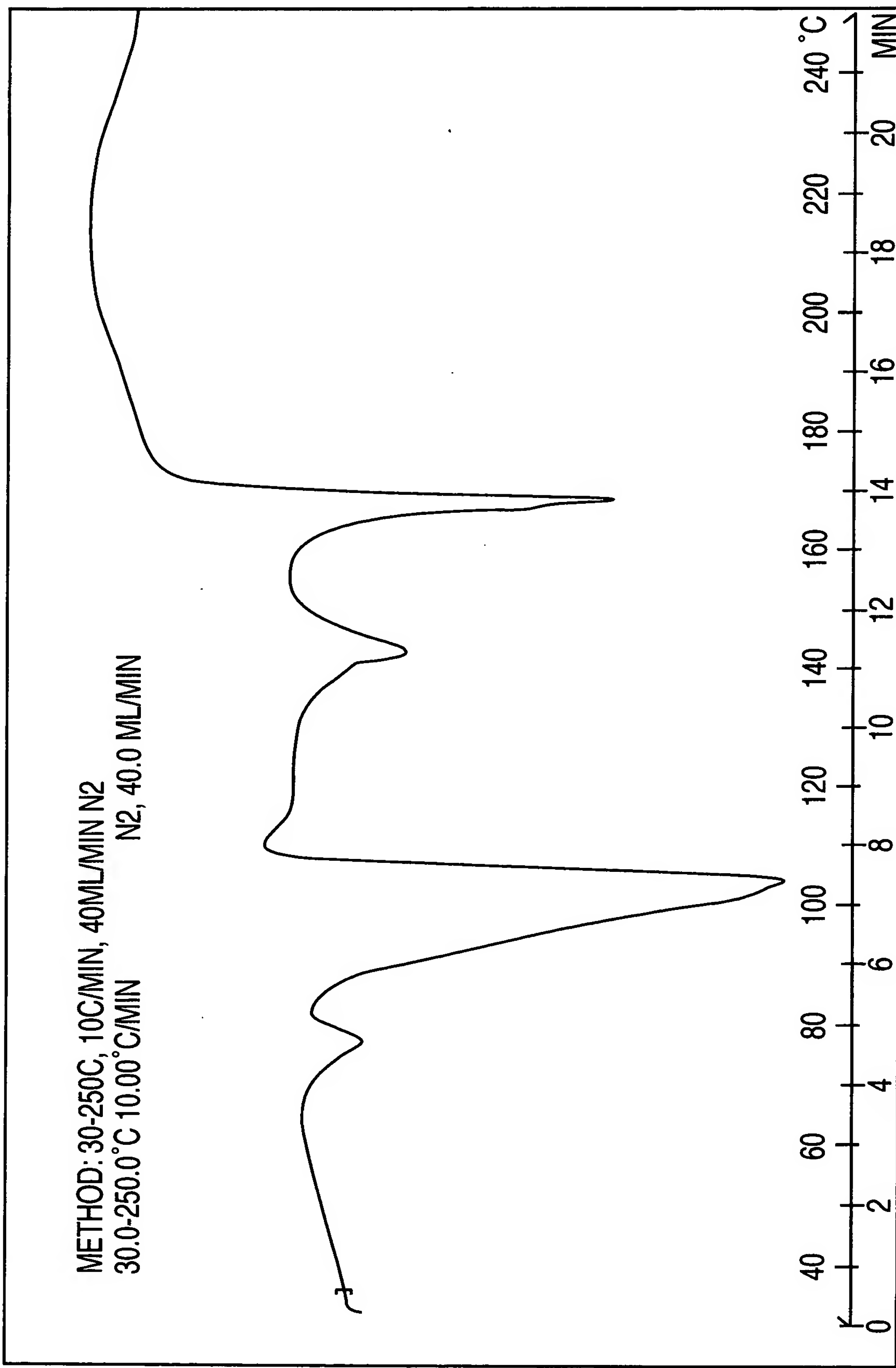


FORM J
METTLER TOLEDO STAR^e SYSTEM

FIG. 42

^EXO

METHOD: 30-250C, 10C/MIN, 40ML/MIN N2
30.0-250.0 °C 10.00 °C/MIN N2, 40.0 ML/MIN



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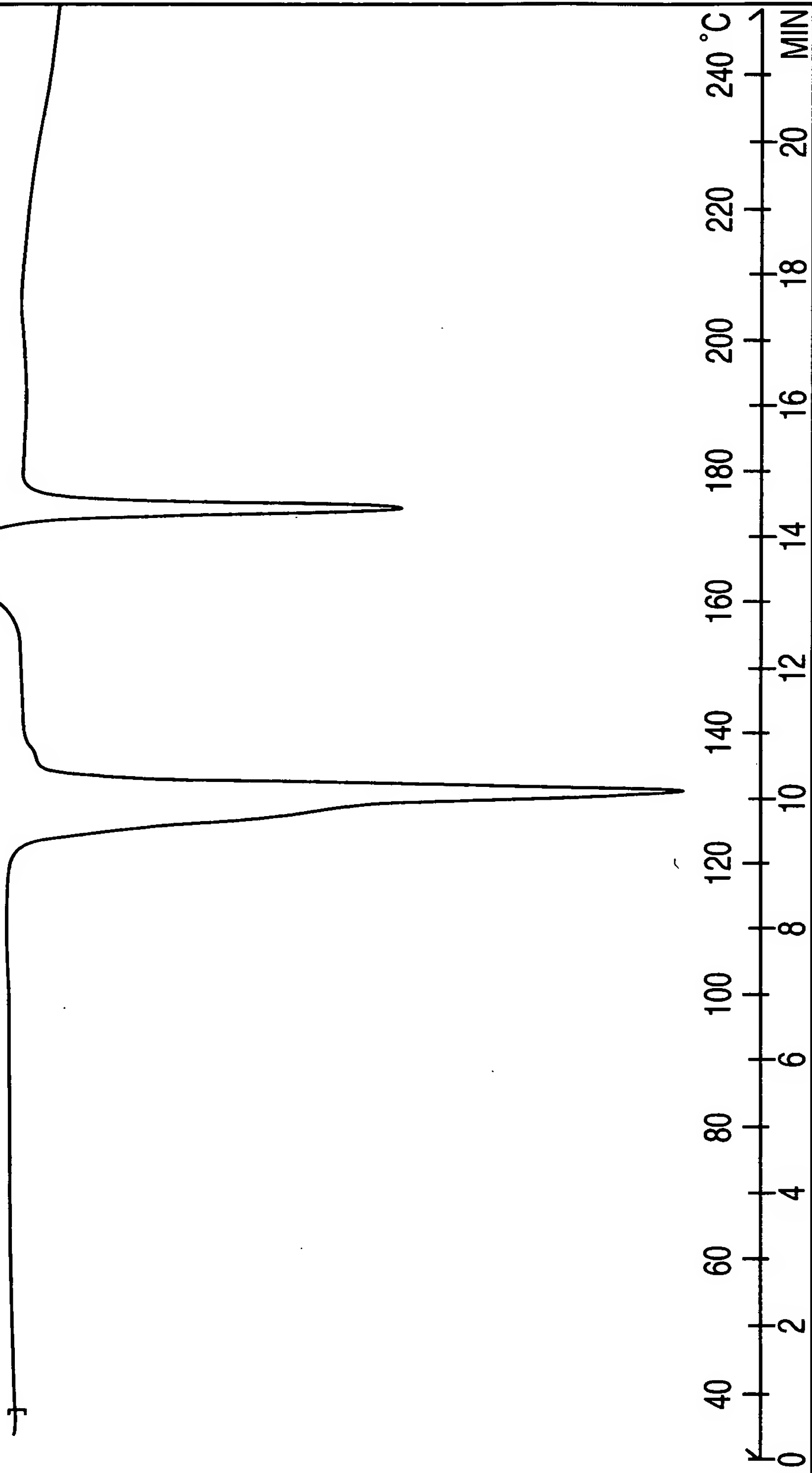
METTLER TOLEDO STAR^e SYSTEM

FORM K

FIG. 43

^EXO

METHOD: 30-250C, 10C/MIN, 40ML/MIN N2
30.0-250.0°C 10.00°C/MIN N2, 40.0 ML/MIN



METTLER TOLEDO STAR^e SYSTEM

FORM L

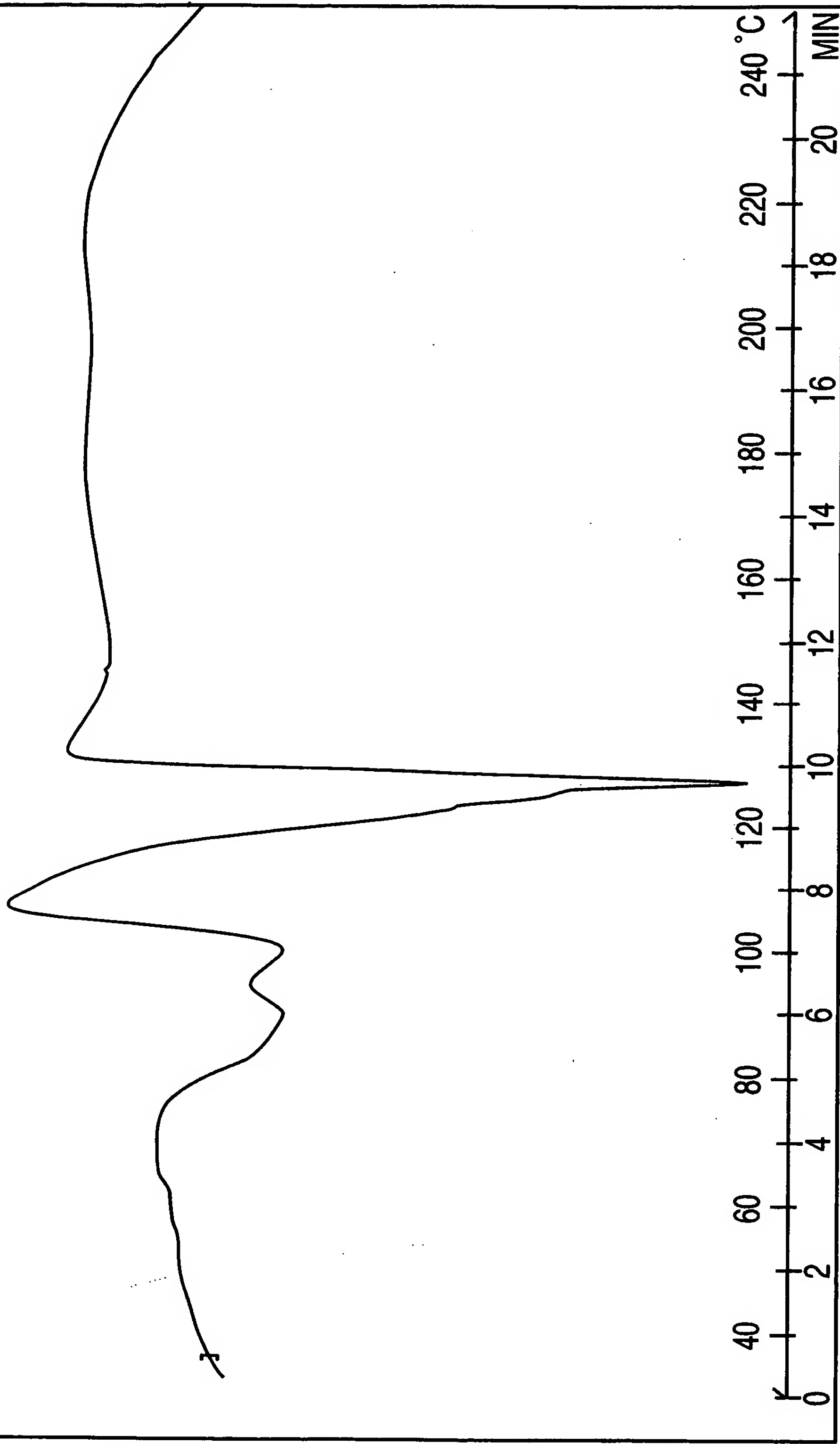
FIG. 44

^EXO

METHOD: 30-250C, 10C/MIN, 40ML/MIN N2

30.0-250.0°C 10.00°C/MIN

N2, 40.0 ML/MIN



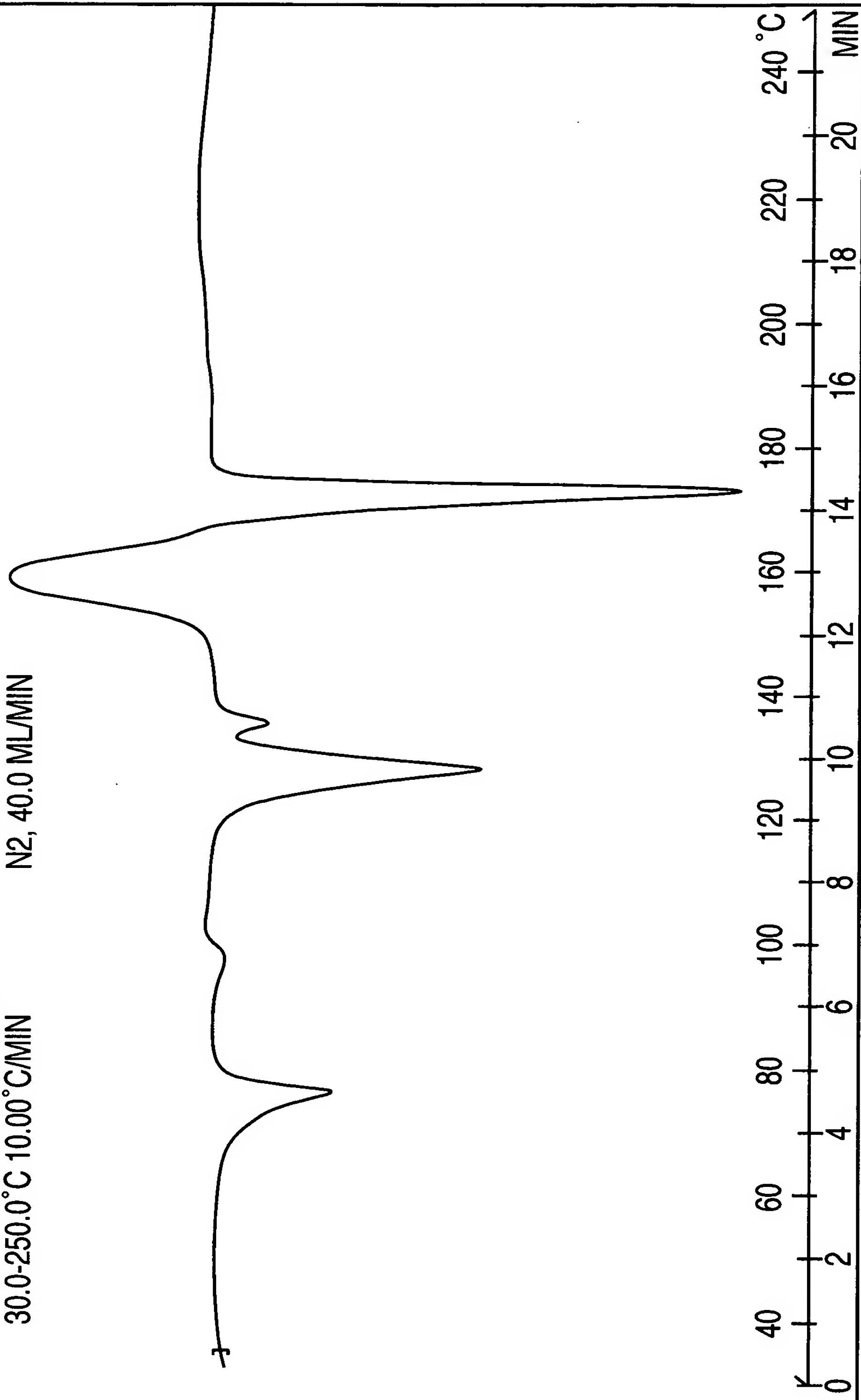
METTLER TOLEDO STAR® SYSTEM

FORM M

FIG. 45

^EXO

METHOD: 30-250C, 10C/MIN, 40ML/MIN N2
30.0-250.0°C 10.00°C/MIN N2, 40.0 ML/MIN



METTLER TOLEDO STAR^e SYSTEM

FORM N

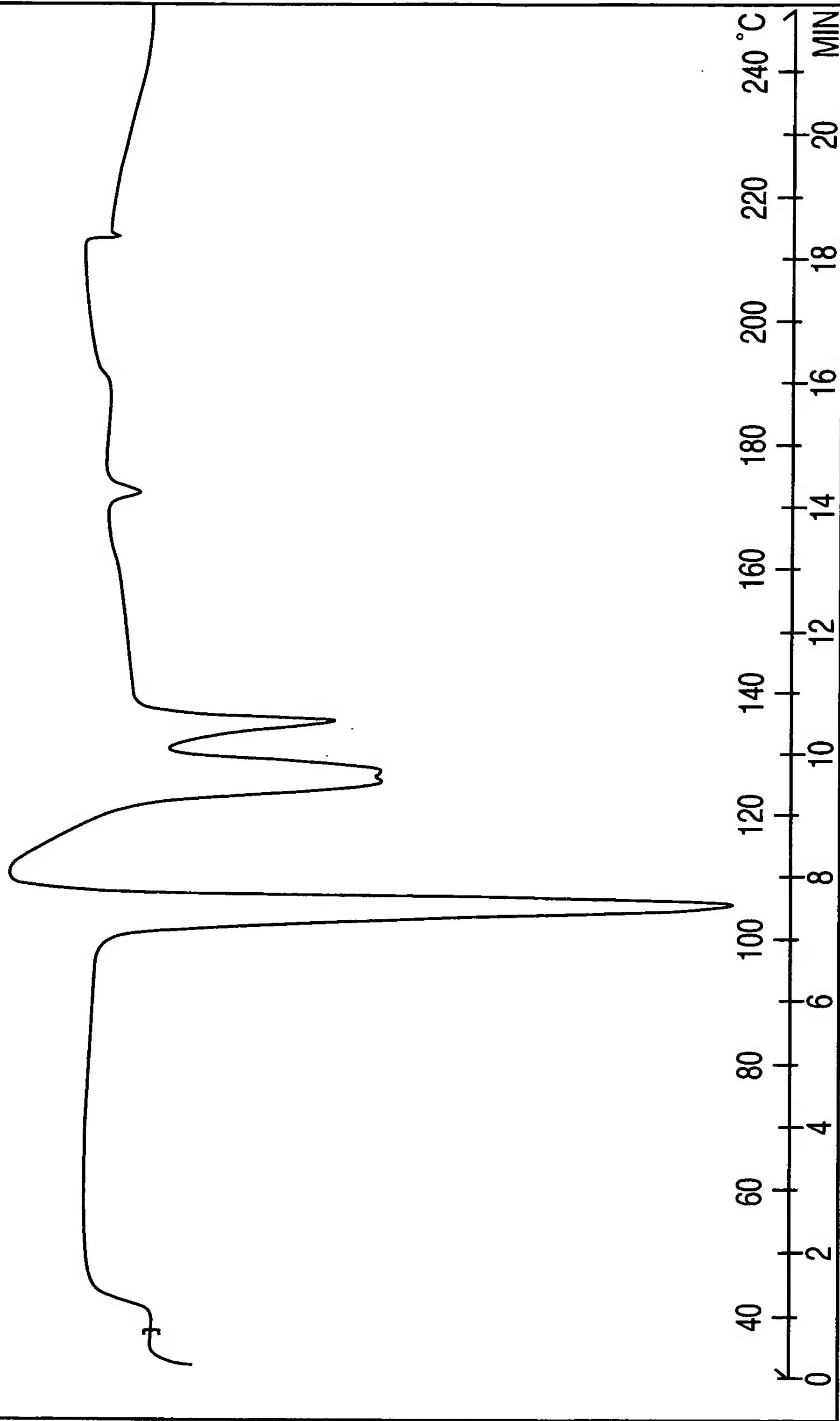
FIG. 46

^EXO

METHOD: 30-250C, 10C/MIN, 40ML/MIN N2

30.0-250.0°C 10.00°C/MIN

N2, 40.0 ML/MIN



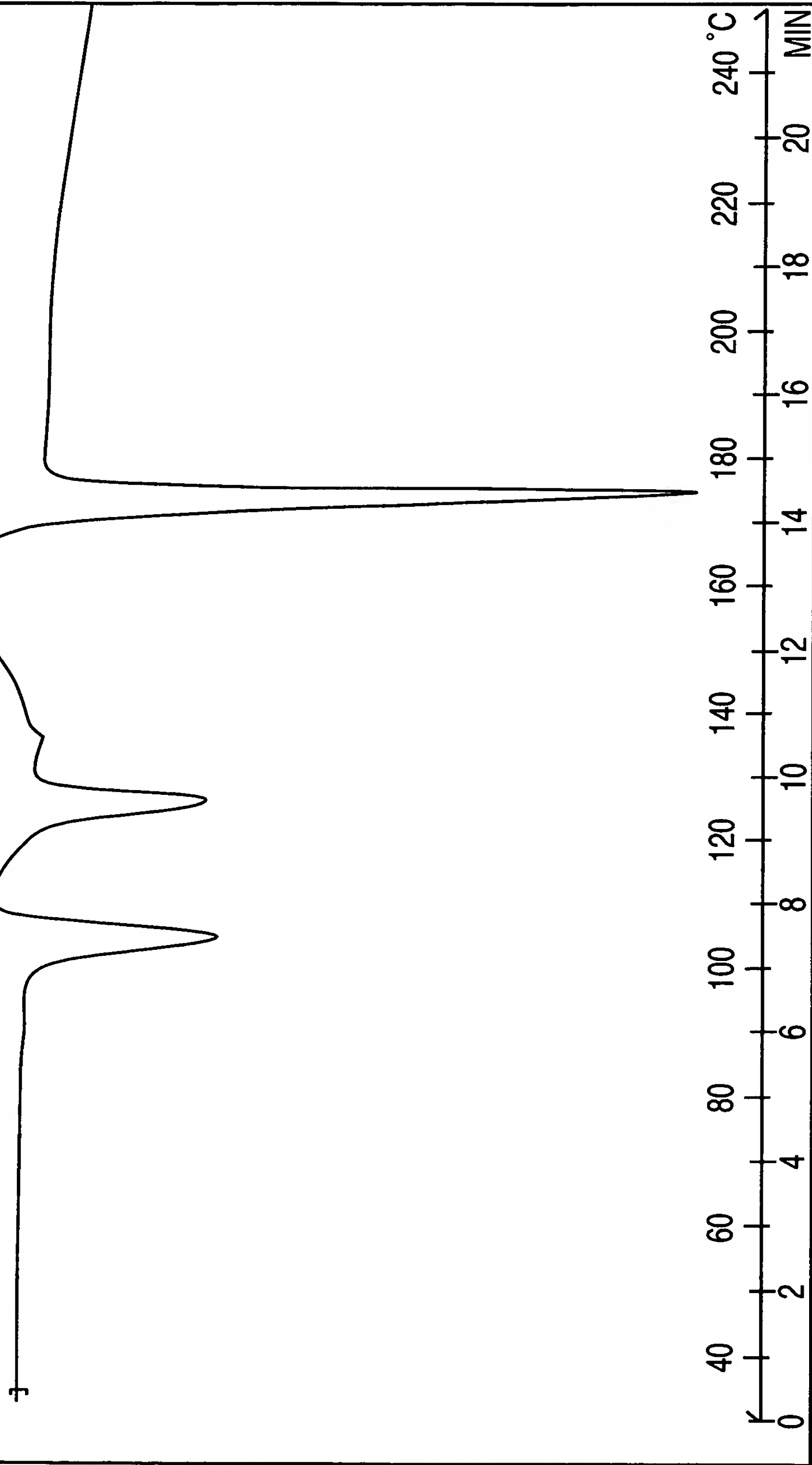
METTLER TOLEDO STAR^e SYSTEM

FORM O

FIG. 47

^EXO

METHOD: 30-250C, 10C/MIN, 40ML/MIN N2
30.0-250.0°C 10.00°C/MIN N2, 40.0 ML/MIN



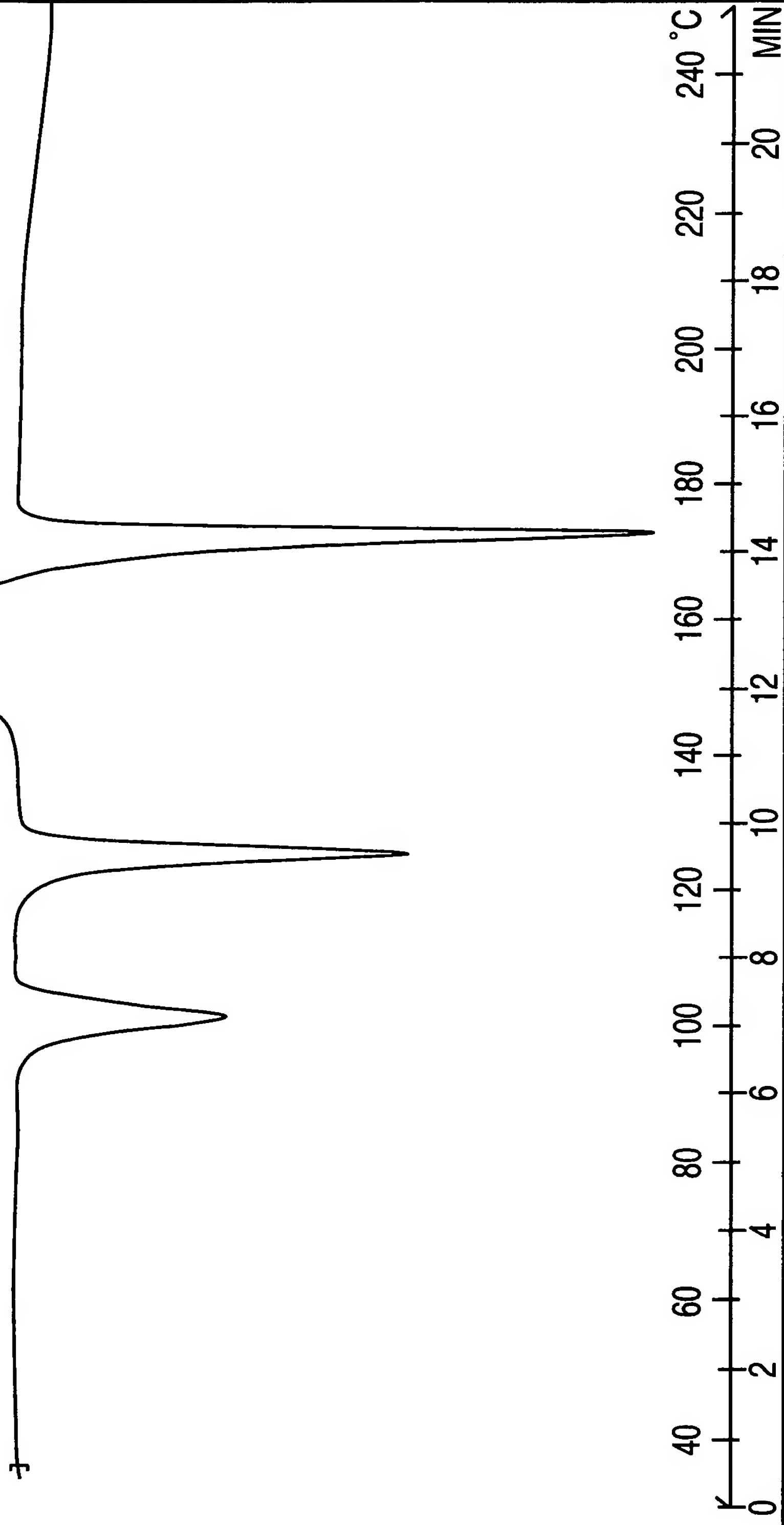
METTLER TOLEDO STAR^e SYSTEM

FORM P

FIG. 48

^EXO

METHOD: 30-250C, 10C/MIN, 40ML/MIN N2
30.0-250.0°C 10.00°C/MIN N2, 40.0 ML/MIN



METTLER TOLEDO STAR^e SYSTEM

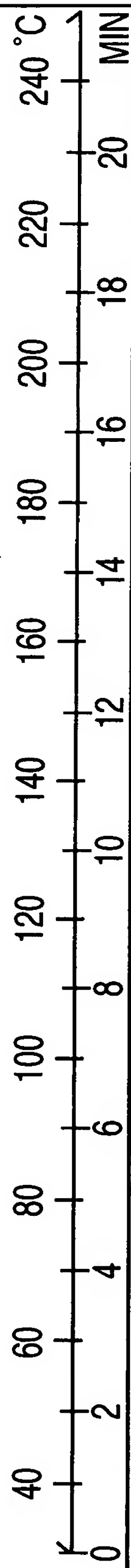
FORM Q

FIG. 49

^EXO

METHOD: 30-250C, 10C/MIN, 40ML/MIN N2
30.0-250.0°C 10.00°C/MIN N2, 40.0 ML/MIN

7



METTLER TOLEDO STAR^e SYSTEM

FORM T

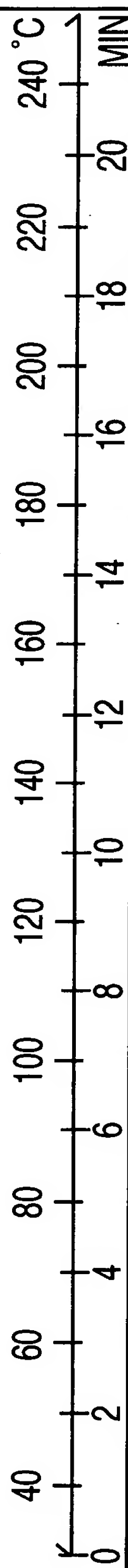
FIG. 50

^EXO

METHOD: 30-250C, 10C/MIN, 40ML/MIN N2

30.0-250.0°C 10.00°C/MIN

N2, 40.0 ML/MIN



METTLER TOLEDO STAR^e SYSTEM

FORM U

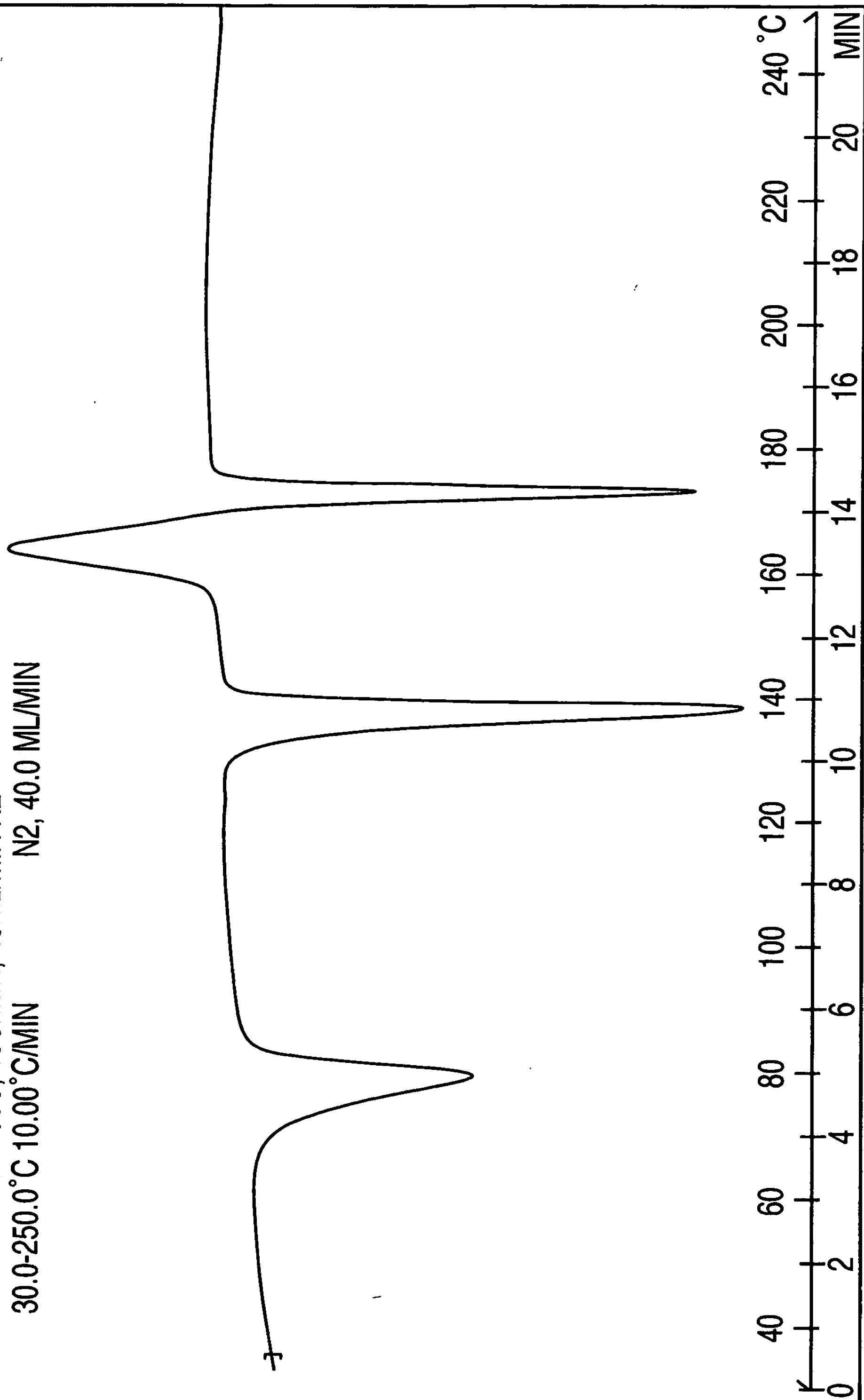
FIG. 51

^EXO

METHOD: 30-250C, 10C/MIN, 40ML/MIN N2

30.0-250.0°C 10.00°C/MIN

N2, 40.0 ML/MIN



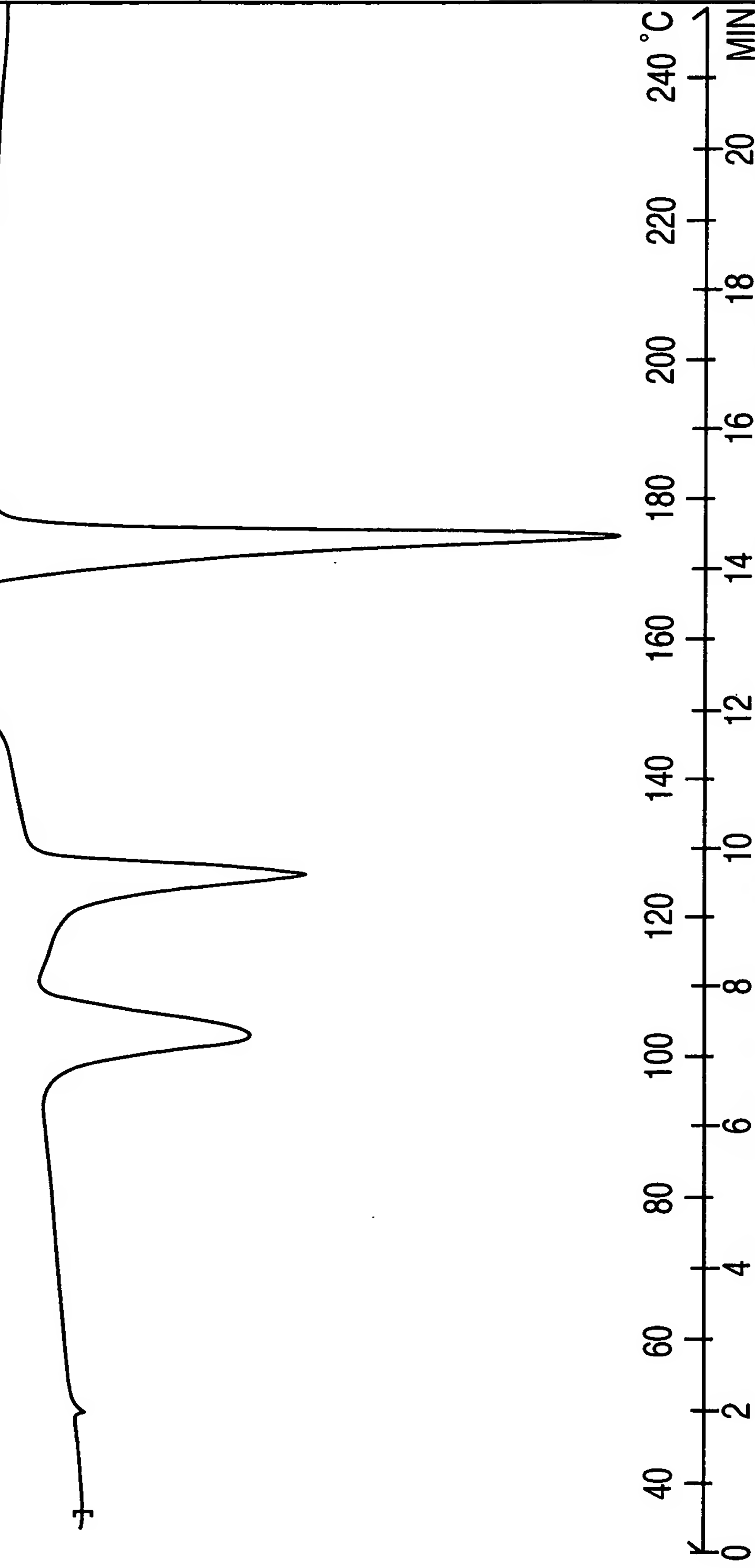
METTLER TOLEDO STAR® SYSTEM

FORM V

FIG. 52

^EXO

METHOD: 30-250C, 10C/MIN, 40ML/MIN N2
30.0-250.0°C 10.00°C/MIN N2, 40.0 ML/MIN



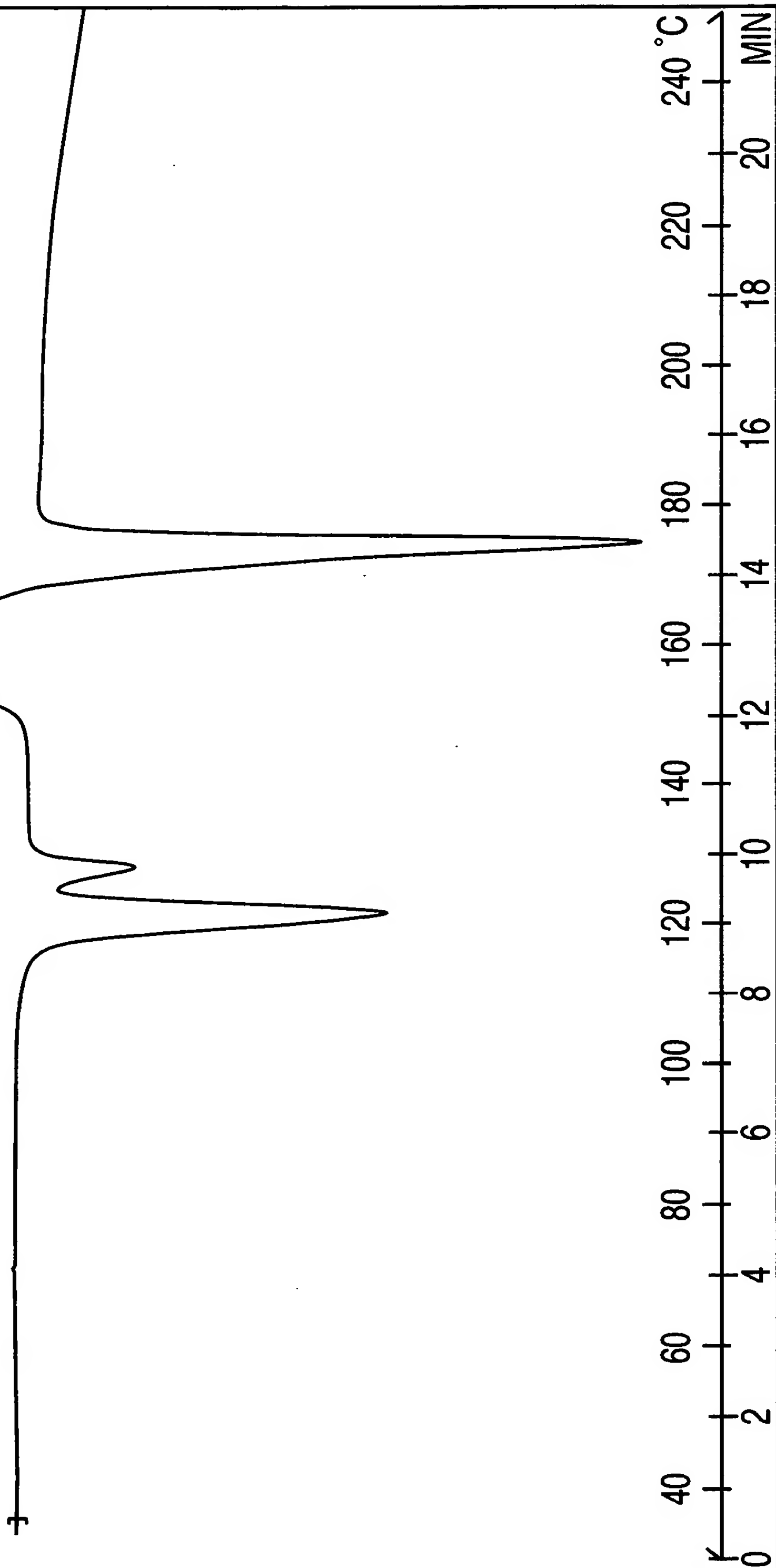
FORM Y (CHLOROFORM SOLVATE)

METTLER TOLEDO STAR^e SYSTEM

FIG. 53

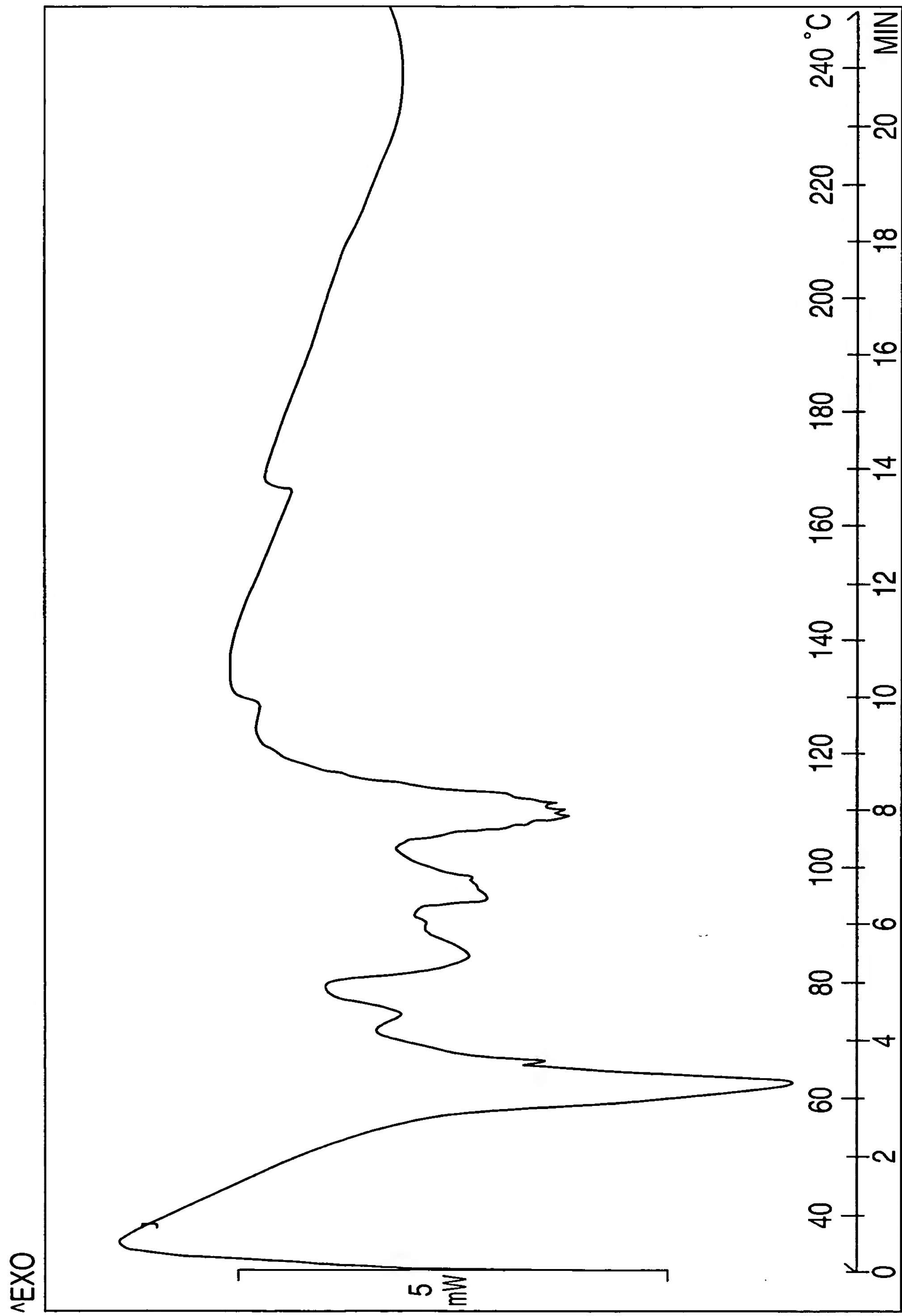
^EXO

METHOD: 30-250C, 10C/MIN, 40ML/MIN N2
30.0-250.0°C 10.00°C/MIN N2, 40.0 ML/MIN



FORM Y (DICHLOROMETHENE SOLVATE) METTLER TOLEDO STAR® SYSTEM

FIG. 54



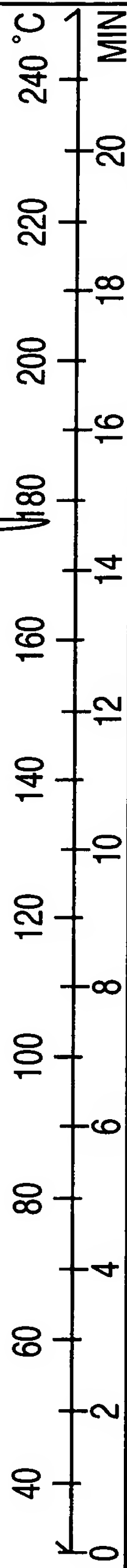
NATEGLINIDE FORM Z METTLER TOLEDO STAR^e SYSTEM

FIG. 55

^EXO

METHOD: 30-250C, 10C/MIN, 40ML/MIN N2
30.0-250.0°C 10.00°C/MIN N2, 40.0 ML/MIN

10
mW

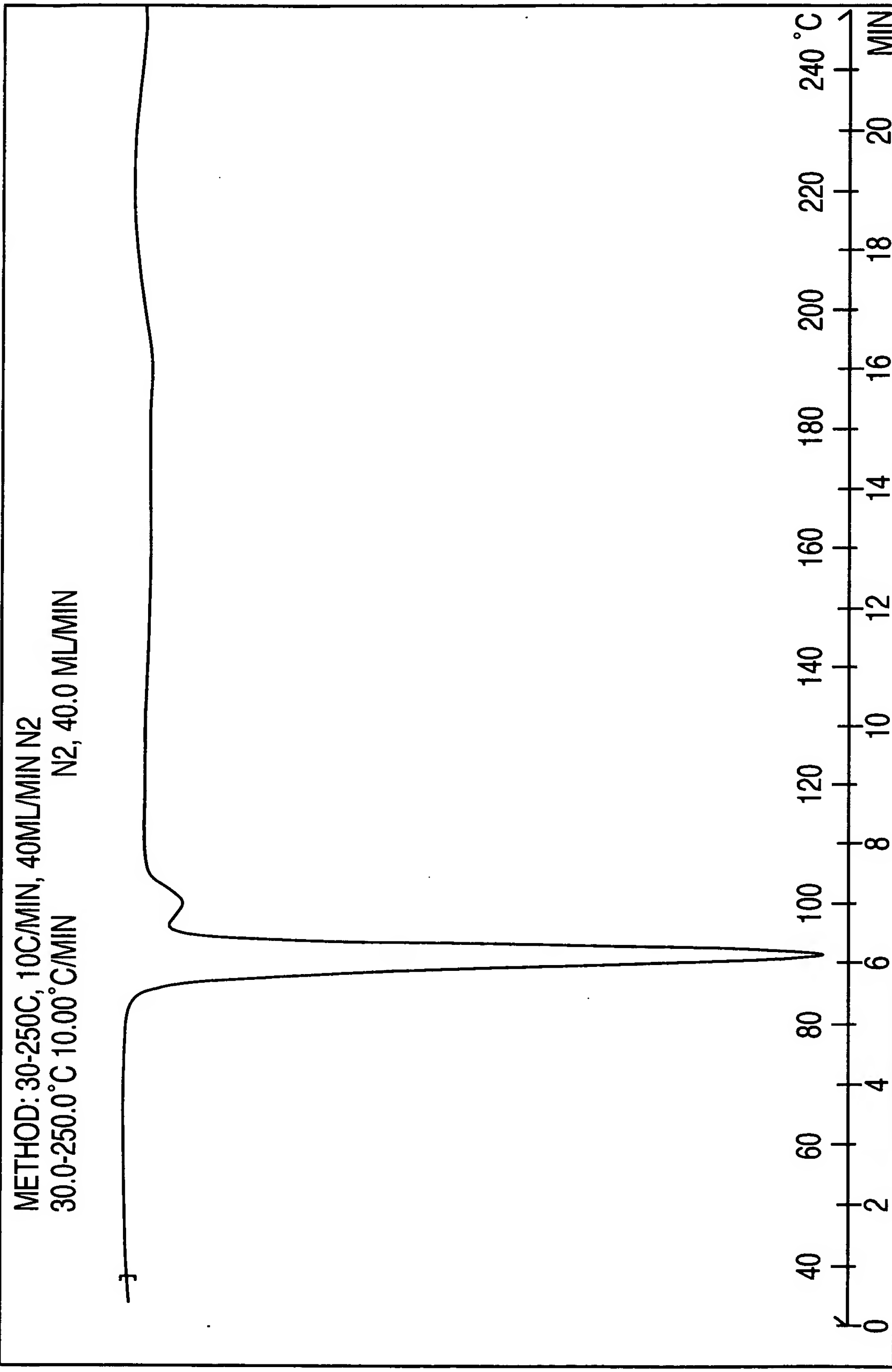


METTLER TOLEDO STAR® SYSTEM

FORM α

FIG. 56

^EXO



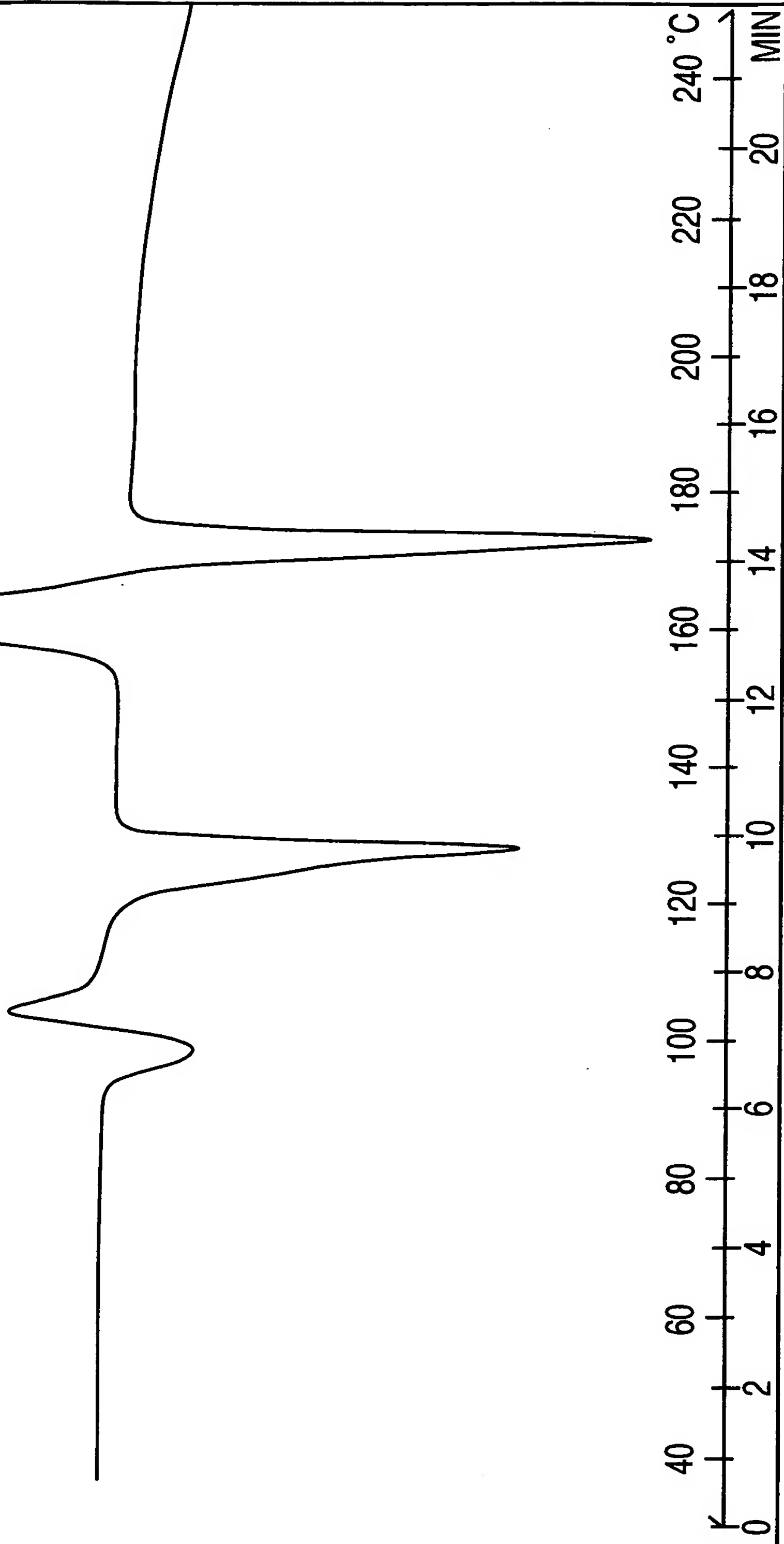
METTLER TOLEDO STAR® SYSTEM

FORM BETA

FIG. 57

^EXO

METHOD: 30-250C, 10C/MIN, 40ML/MIN N2
30.0-250.0°C 10.00°C/MIN N2, 40.0 ML/MIN



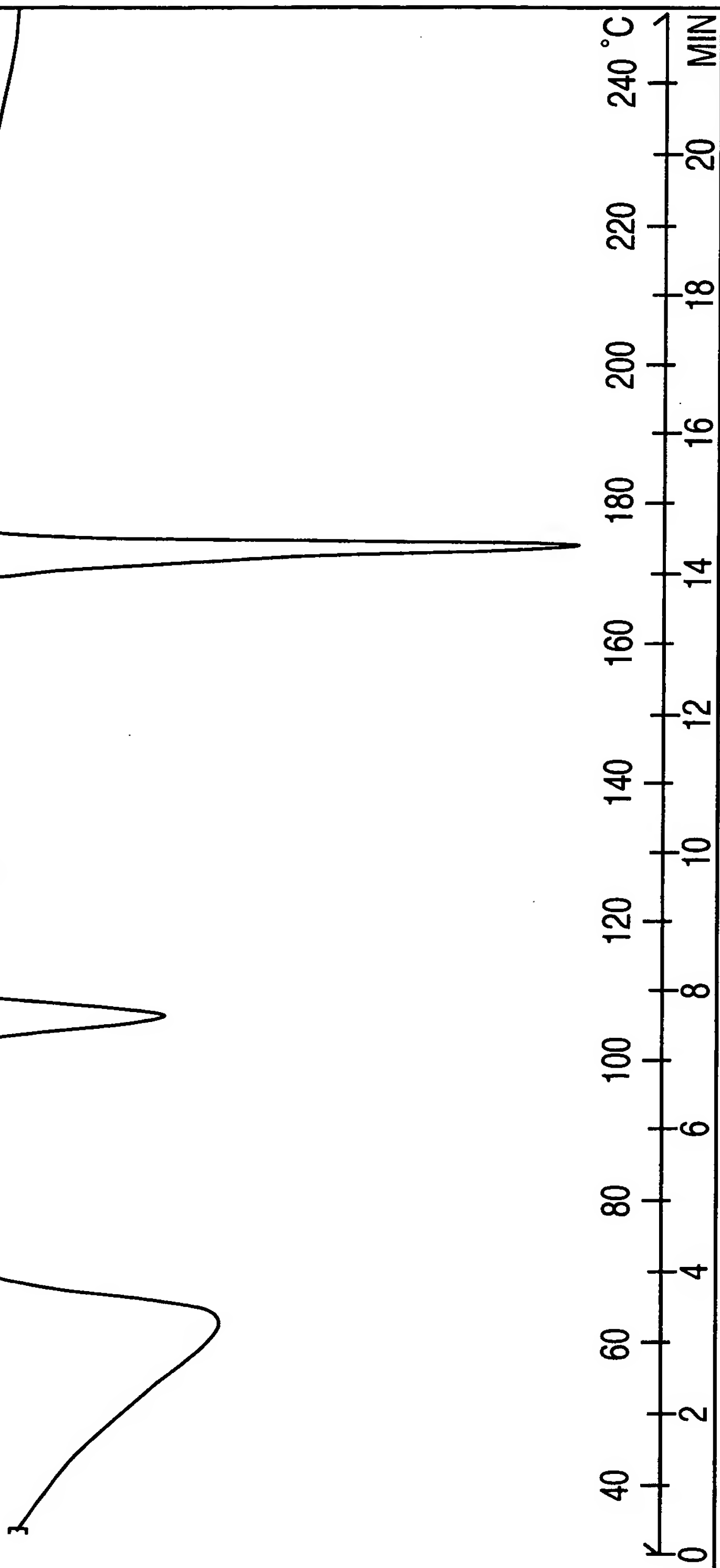
METTLER TOLEDO STAR® SYSTEM

FORM DELTA

FIG. 58

^EXO

METHOD: 30-250C, 10C/MIN, 40ML/MIN N2
30.0-250.0°C 10.00°C/MIN N2, 40.0 ML/MIN

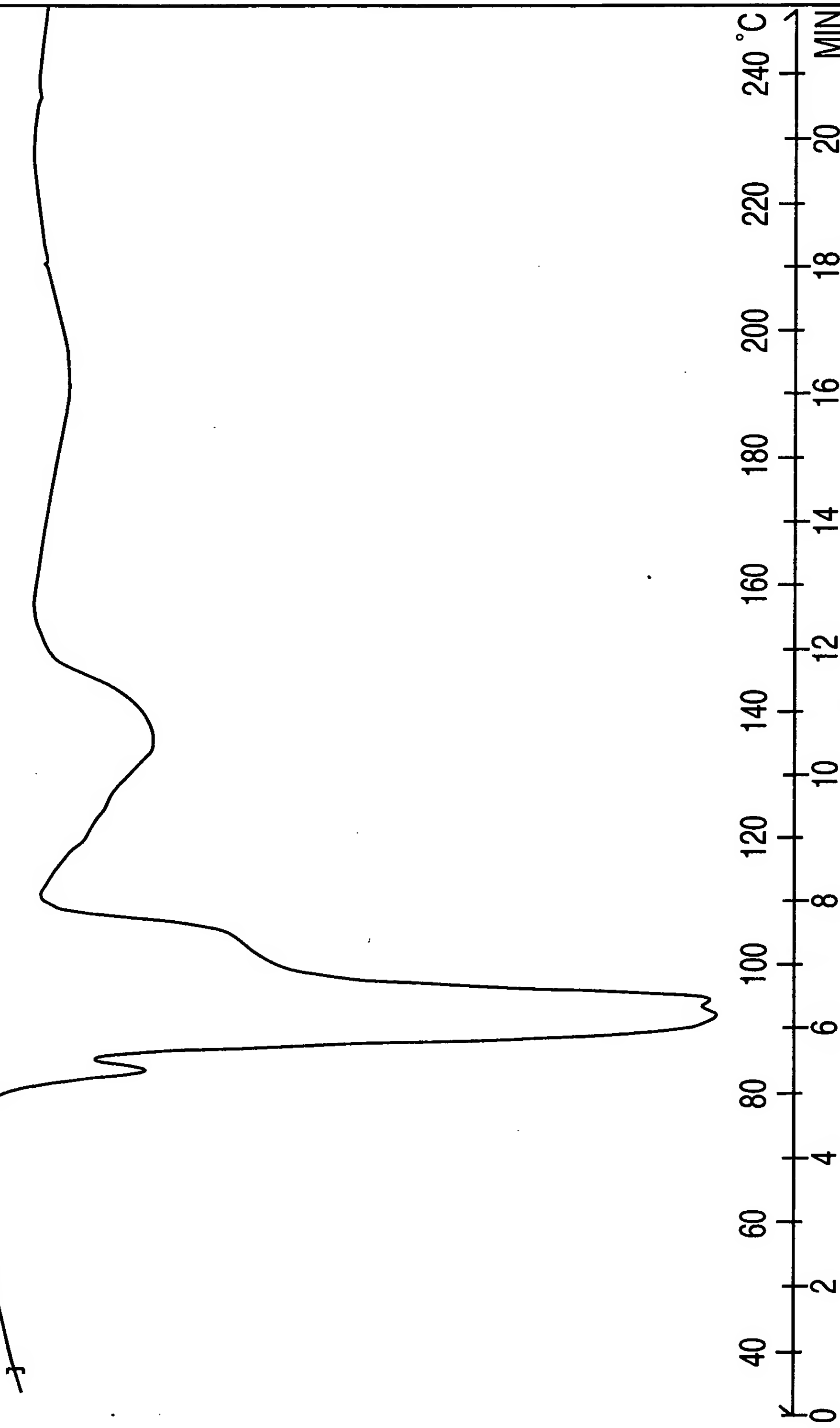


FORM EPSILON
METTLER TOLEDO STAR^e SYSTEM

FIG. 59

^EXO

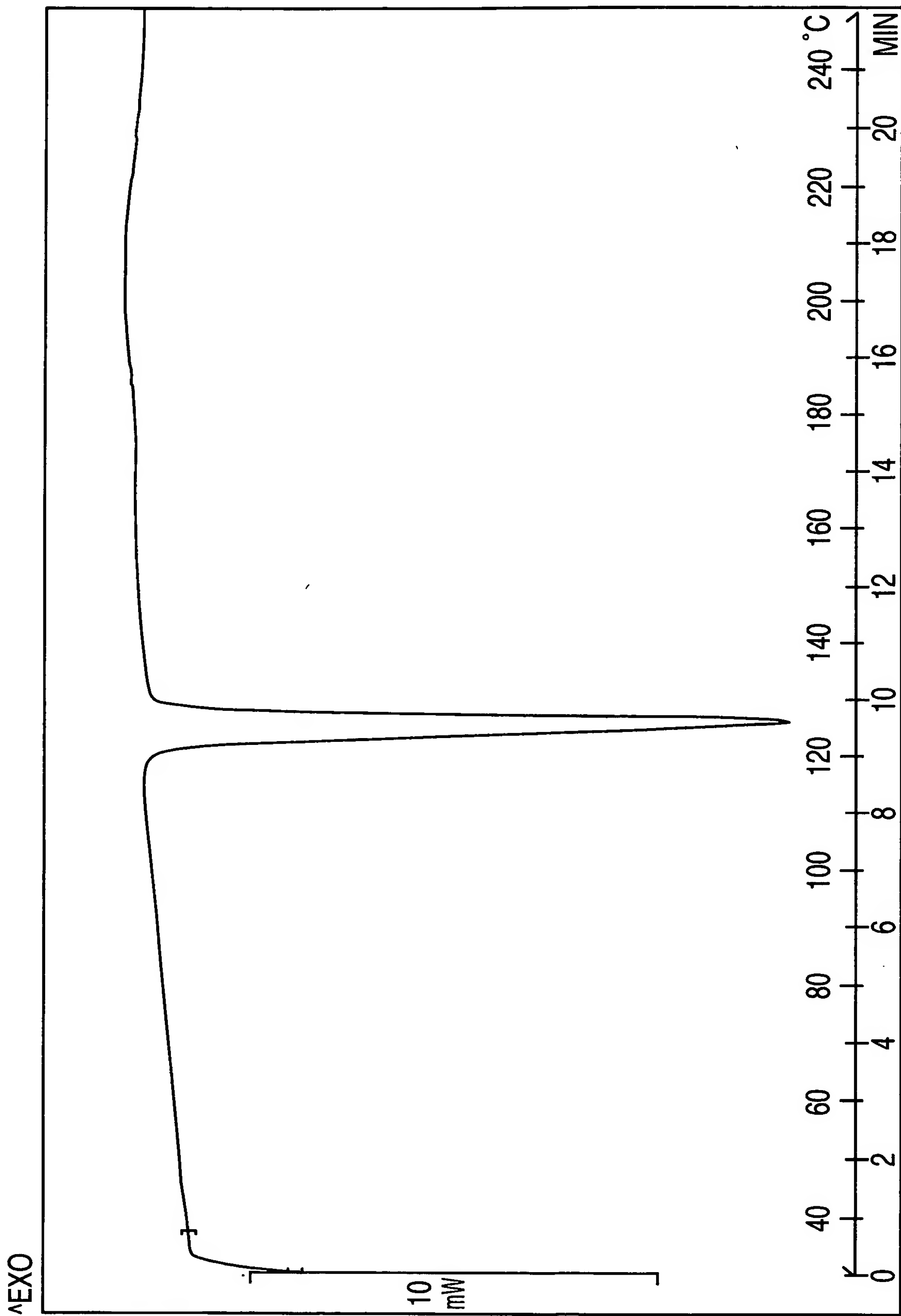
METHOD: 30-250C, 10C/MIN, 40ML/MIN N2
30.0-250.0 °C 10.00 °C/MIN N2, 40.0 ML/MIN



FORM GAMMA

METTLER TOLEDO STAR® SYSTEM

FIG. 60

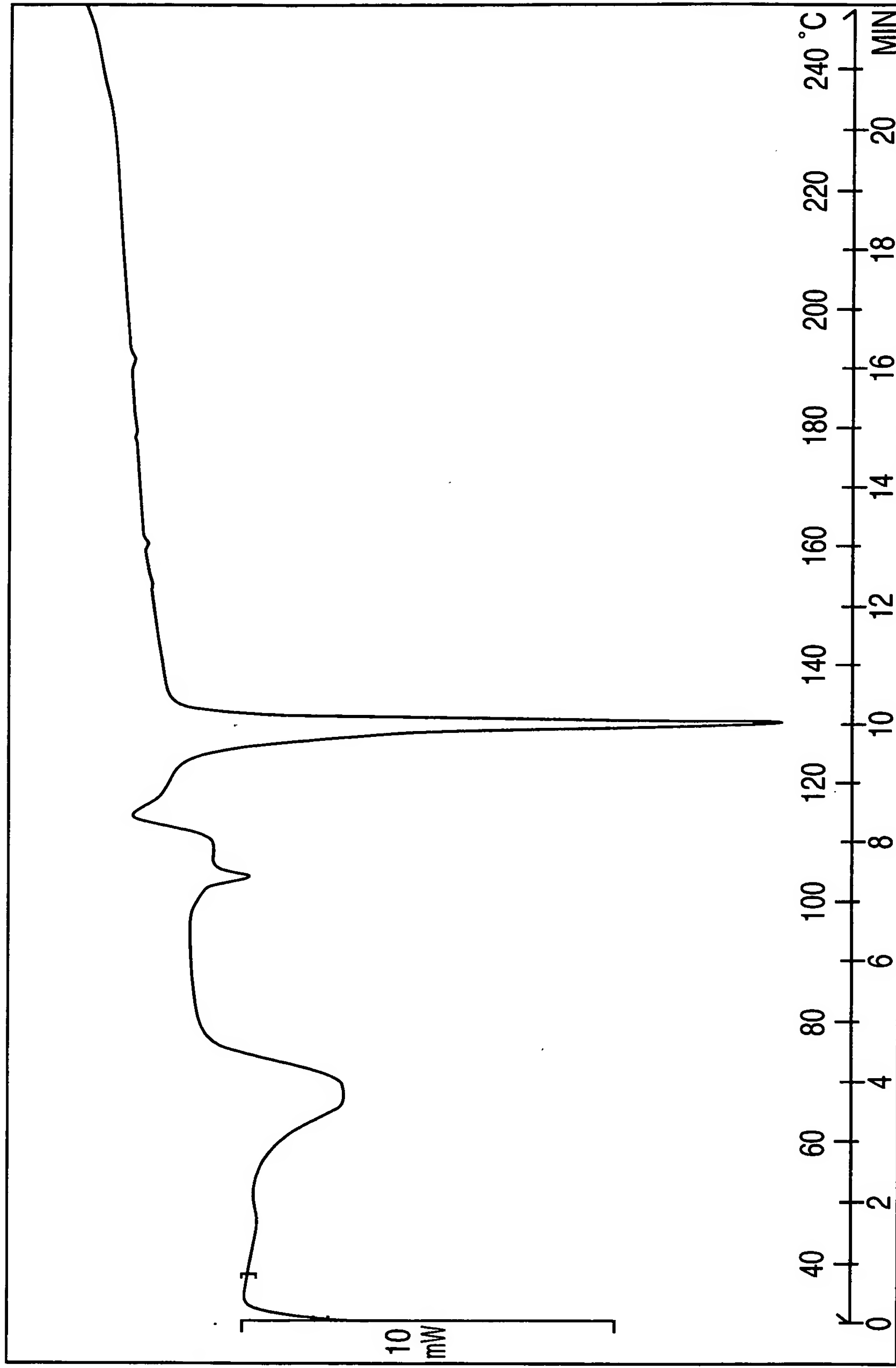


METTLER TOLEDO STAR^e SYSTEM

FORM SIGMA ~ (σ)

FIG. 61

^EXO



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METTLER TOLEDO STAR^e SYSTEM

FORM THETA σ

FIG. 62

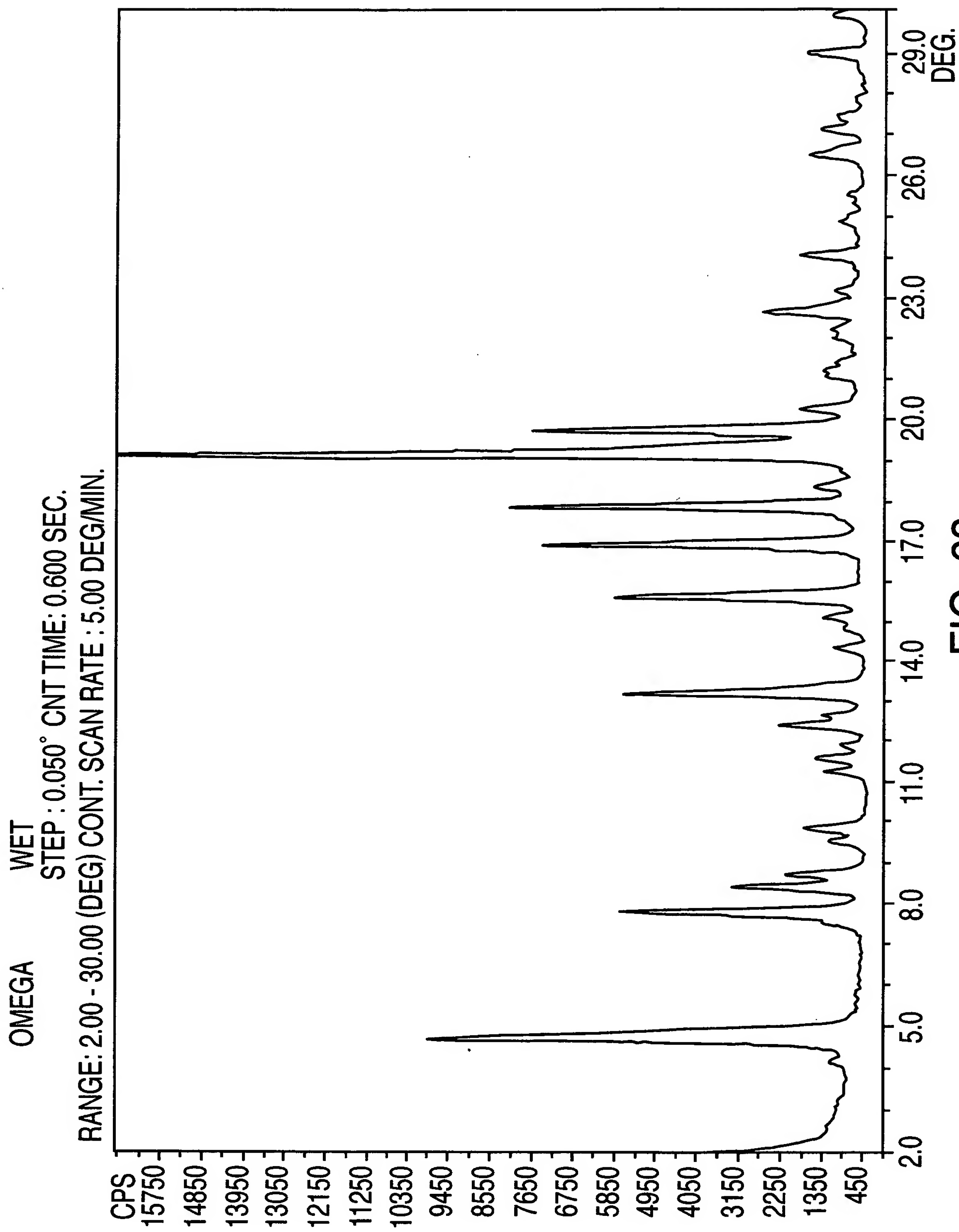


FIG. 63

Comparison between the impurity profile of Nateglinide crystallized in IPA-H₂O and Nateglinide in Methanol-H₂O

Sample No	Solvent	Impurity prfile by RRT [% w/w]								
		D-PA (0.23)	(0.25)	(0.46)	(0.80)	Ipcha (0.89)	Dimer (1.38)	Methyl Ester (1.51)	(1.76)	Isopropyl Ester (2.3)
RL-2155/1	Methanol-H ₂ O	<0.01		0.02	<0.01	0.03	0.02	2.91	0.04	
RL-2163/4	IPA-H ₂ O	<0.01	0.04		0.02	0.02	0.01		0.03	0.02

Note: D-PA means D-Phenyl Alanine
 Ipcha means Iso propyl cyclohexyl carboxylic acid
 Both are the starting materials of the product
 (-)-N-[(trans-4-isopropyl cyclohexane)carbonyl]-D-phenylalanine

FIG. 64